Model 61, 62, & 63H

1) Select the Bookmark option

2) Click on appropriate Service Notice

Service Notice Numbering and Tracking System

The following layout is using a single part number for reference

65L614 Rubber Plug

8 characters used as a "File Name" on the computer system.

060 14 001

Subdivision related to the part "14" which will continually increase as the number of Lubrication Notices are created.

Type of part - Main Division, such as "14" for Lubrication or "44" for Shafts or "00" for an assembled component.

Designates Seamer Model Number

Revisions to existing Service Notices will be as follows:The "File Name" will be duplicated on the Service Notice with the latest revision level designated by a letter.
Example: 06014001"A". Revision levels on Service Notices are rare but can happen. The Service Notice will provide remaining needed information.

1/20/99-06133001

5 and 7 Feed Lubricators (4H614 or 38L814), Low Oil Level Switch Modification.

Scope:
Models 61H, 62H, 80L, 81L, 100L, 101L, 120L and 121L Seamers have been in the past equipped with a Low Oil Level Sensor in the Lubricator to warn the Operator, by a flashing indicator, when to refill the reservoir. These instructions are prepared to retrofit a High/Low Oil Level Sensor (750L833).

Description:
The High/Low Oil Level Sensor Retrofit provides a means to refill the reservoir without guess work as to how many quarts it will take to fill it up. This retrofit also allows refill to take place without opening doors to enclosures which would normally by design shut down the Seamer. When oil reaches the Low level sensor, an flashing indicator warns the Operator to refill. When Oil reaches the High Level Sensor the flashing indicator will go out. This allows refill from outside an Enclosure that will not require shutting down the Seamer when opening doors.

Follow the next steps to retrofit the Lubricator;

1. Remove the Lubricator cover from the reservoir.

2. Disconnect Low Oil Level Probe (226L833 or 417L833) shielded cable wires from terminals or splices located at terminal box.

3. Remove Probe from the lubricator and install the Hole cover (45L833) in the sensor mounting hole using the 10-32 nut provided.

4. Drill a .406 (10,3mm) clearance hole on the Lubricator Cover as shown on the sketch (page 3).

5. Install the High/Low Oil Level Switch (750L833) in the Cover hole using the 1/8 NPT brass nut provided.

6. Before placing the Cover back onto the reservoir, clean out all sediment and sludge that has gathered at the bottom. Reassemble the Lubricator Cover.

7. Connect High/Low Oil Level Sensor witch wires to terminal or splice to existing cable. See Electrical diagram on the last page.

Reference Data Sheet G-120.75

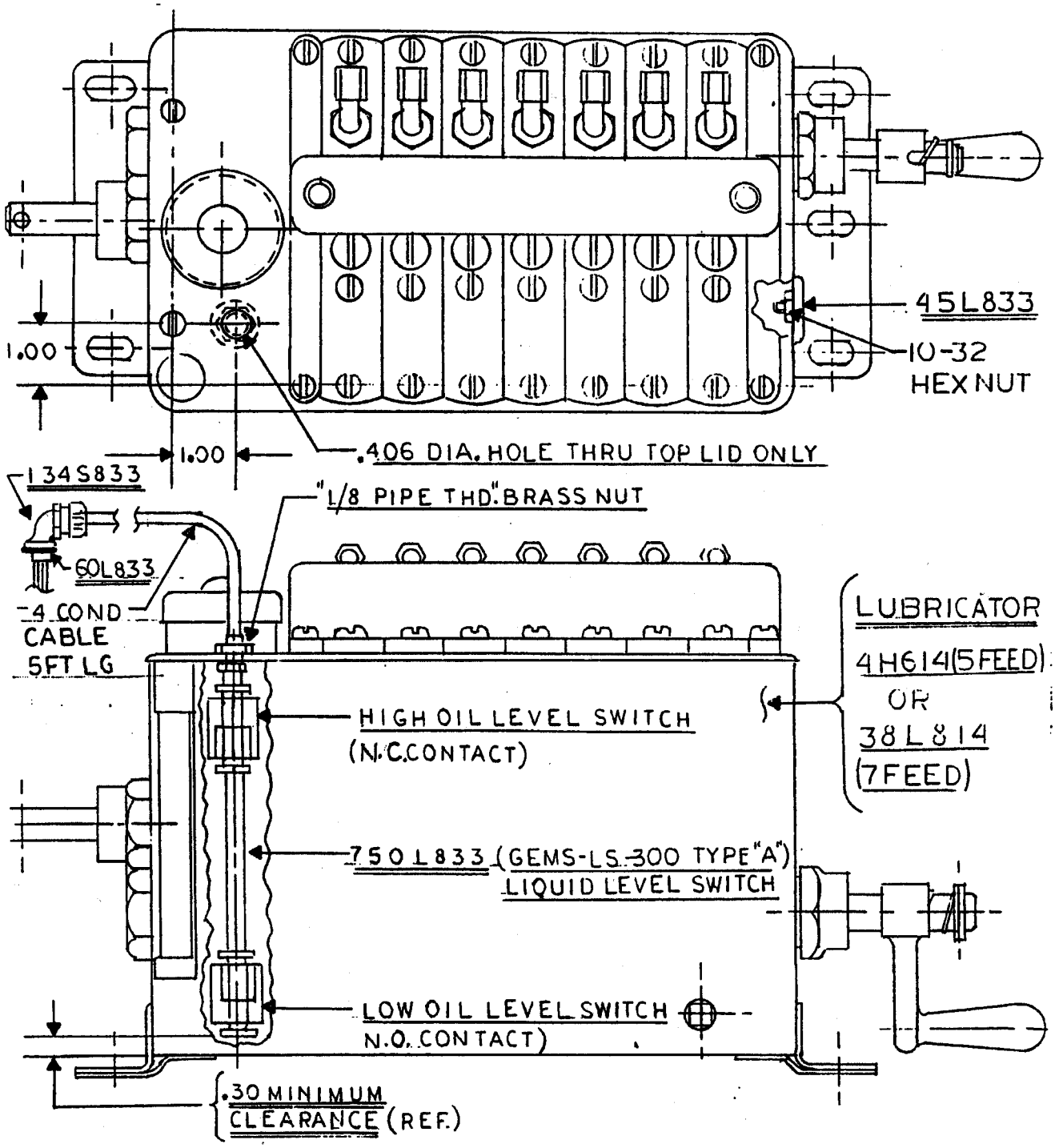
PARTS REQUIRED TO REPLACE THE LOW OIL LEVEL PROBE AND RELAY
PARTS 225L833 & 226L833 ON 120VAC CONTROLS

ITEM	DESCRIPTION	QTY	ANGELUS PART
1	HOLE COVER	1	F 045L833 AAA 6
2	10-32 HEX NUT	1	
3	O-RING, WITH RETAINER	1	F 060L833 AAA 6
4	3 POLE RELAY 120VAC	1	F 358L833 AAA 7
5	RELAY SOCKET	1	F 359L833 AAA 6
6	HIGH-LOW OIL LEVEL SWITCH	1	F 750L833 AAA I
7	1/8 PIPE THREAD-BRASS NUT	1	
8	CORD GRIP	1	F 134S833 AAA 0

PARTS REQUIRED TO REPLACE THE LOW OIL LEVEL PROBE AND RELAY
PARTS 417L833 & 418L833 ON 24VDC CONTROLS

ITEM	DESCRIPTION	QTY	ANGELUS PART
1	HOLE COVER	1	F 045L333 AAA 6
2	10-32 HEX NUT	1	
3	O-RING WITH RETAINER	1	F 060L833 AAA 6
4	RELAY SOCKET	1	F 359L833 AAA 6
5	3 POLE RELAY 24VDC	1	F 419L833 AAA 4
6	DIODE	1	F 421L833 AAA 0
7	HIGH-LOW OIL LEVEL SWITCH	1	F 750L833 AAA I
8	1/8 PIPE THREAD-BRASS NUT	1	
9	CORD GRIP	1	F 134S833 AAA 0

HIGH LOW OIL LEVEL SWITCH
INSTALLATION FOR 5 OR 7 FEED LUBRICATOR
(7 FEED LUBRICATOR SHOWN)
DRAWING NOT TO SCALE



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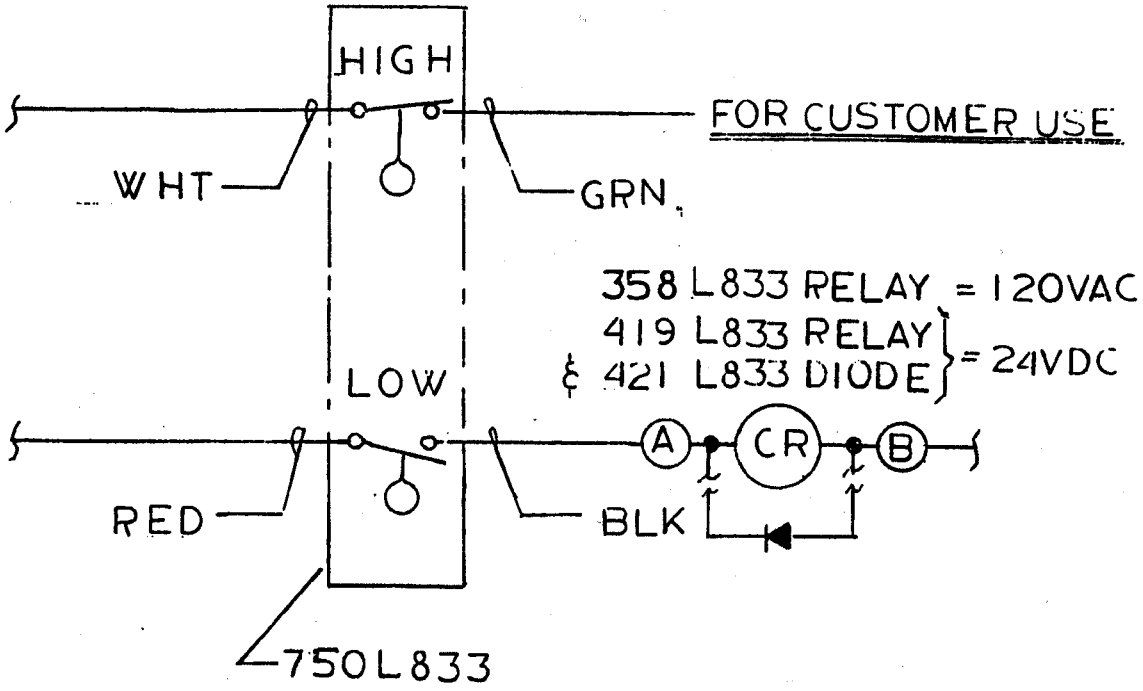
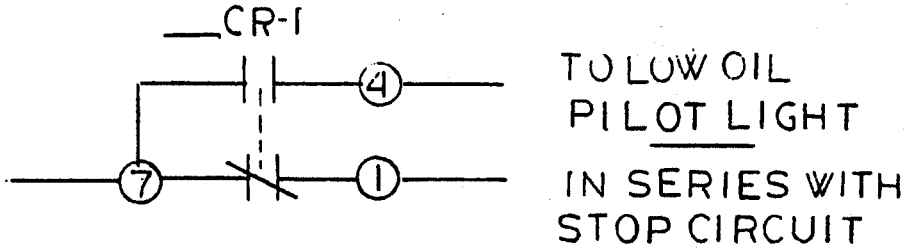
CONNECT HIGH-LOW OIL LEVEL SWITCH & RELAY

FOR 24VDC & 120VAC CONTROLS AS SHOWN BELOW





SERVICE NOTICE

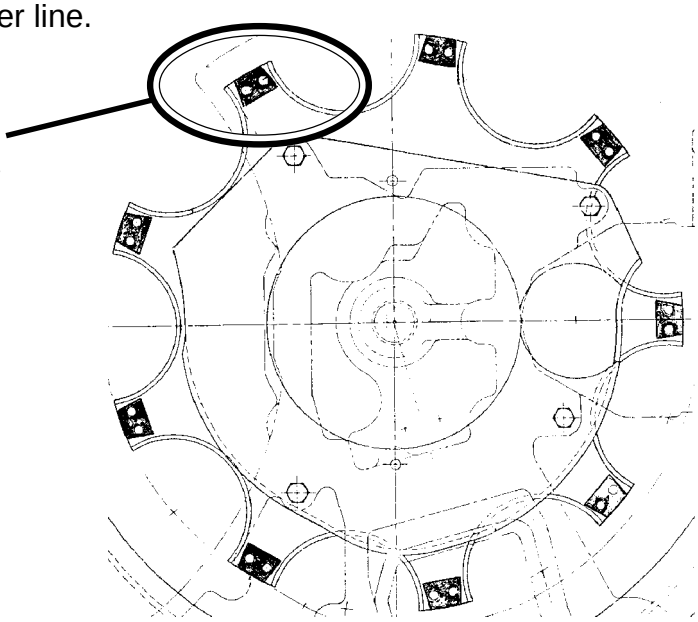
12/25/95-06159001

Model 62H Seamer Feed Turret Cap Pushers

When installing Cap Pushers on the Feed Turret there are two important factors involved.

1st The angle cut on each end of the Cap Pusher is always positioned with the longer side of the Cap Pusher towards the Feed Turret center line.

All Cap Pushers are assembled in this manner.



2nd Some Cap Pushers have an undercut along the back curve of the Cap Pusher and must be installed with the undercut facing up and towards the center line. This undercut provides clearance for the Separator Disc during operation.

Model 61H Seamer

Equipped with Mechanical Filler Drive Seamer Safety Clutches

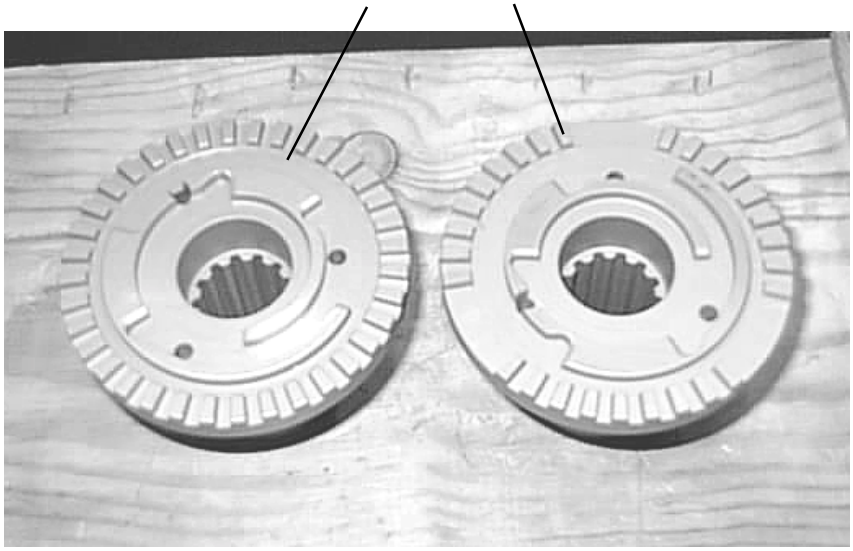
Subject:

Filler Drive Clutch Hubs
Seamers connected to Fillers with 40 Valves or less require a different Clutch Hub.

Description:

The Standard 27L897 Clutch Hub has a row of teeth all around the outside perimeter. These Clutch Hubs are designed to pull the heavier loads enforced by the larger Fillers.
The 42L897 Clutch Hub has been modified to function properly under lighter loads enforced by the smaller Fillers. This modification removed a series of teeth which in turn reduced the surface contact area or friction between the Hubs.

Filler Drive Clutch Hub 27L897 & 42L897



ANGELUS®

SERVICE NOTICE

8/4/97-06200001

Model 62H Quick Change Seaming Roll Levers

Removal & Installation Procedures

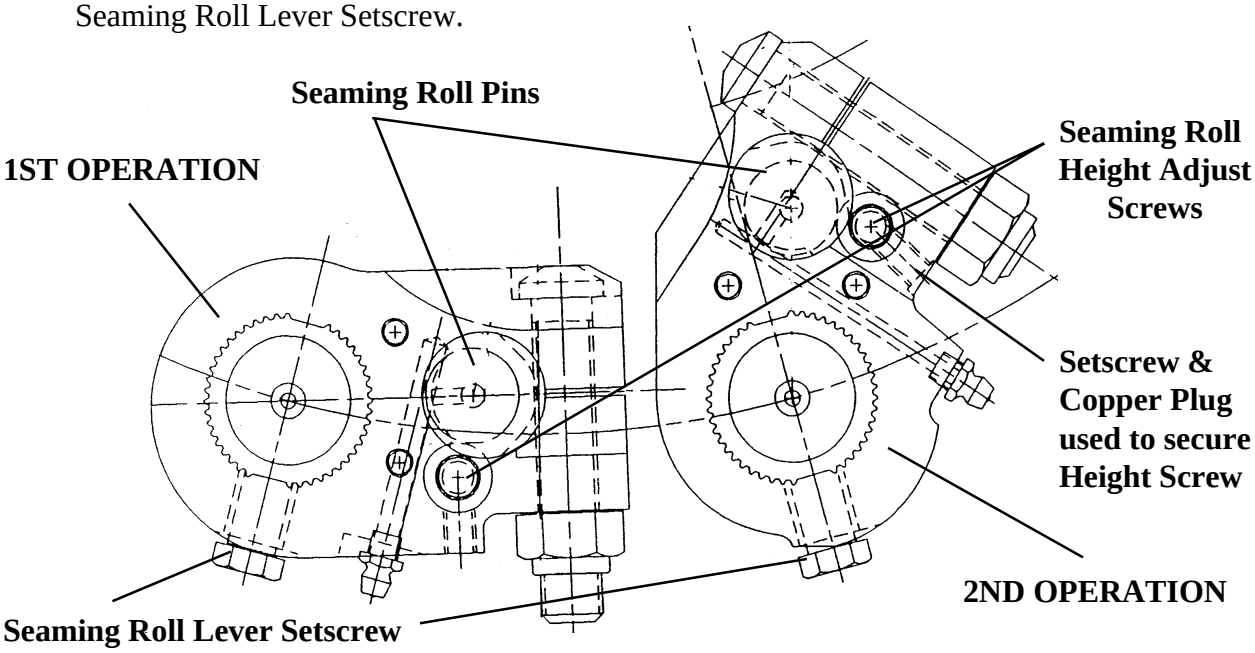
Tools Required;
Initial Installation
1/2" Box End Wrench
Feeler Gage

To remove Seaming Roll Levers;

1st Rotate the Seaming Turret, using the Jog mode or Handwheel, to position a seaming station within Seam Setting Plates located on the Lower Turret Guard.

2nd Use the 1/2" box end wrench to loosen Seaming Lever Set Screw until the Lever can be removed from the Shaft. Do Not replace Thrust Washers. Use the same Thrust Washers with the new Roll Lever.

3rd *Install the Replacement Lever aligning splines and the Set Screw countersink, and secure the Seaming Roll Lever Setscrew.


Seaming Roll Pins
1ST OPERATION
Seaming Roll Height Adjust Screws
Setscrew & Copper Plug used to secure Height Screw
2ND OPERATION
Seaming Roll Lever Setscrew

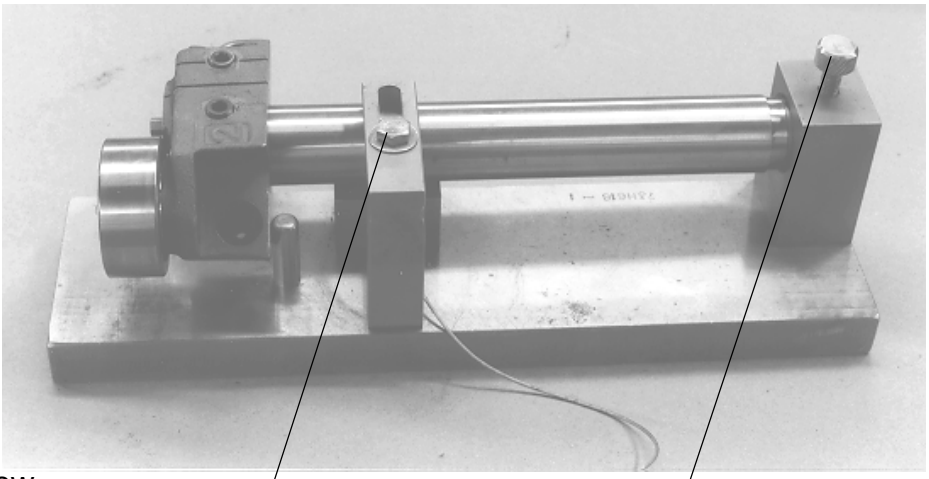
***NOTE:**
***Seaming Rolls and Levers can be taken down as an assembly between the 1st and 2nd operation seam cycle, at or near the Timing pin (90^0 mark).**

Quick Change Seaming Roll Levers are designed to be removed and replaced with a different size Lever without having to readjust Seaming Roll height over the Seaming Chuck or Double Seam settings.
Always check endplay between the Seaming Cam Lever and Upper Turret surface. .002" minimum to .005" maximum.

Seaming Roll profile clearance over the Seaming Chuck Flange (.001/.003 for 1st Oper. Rolls and .006 for 2nd Oper. Rolls) and Double Seam settings should be adjusted and secured prior to change overs to benefit from the Quick Change Parts.

9/27/96-06200002

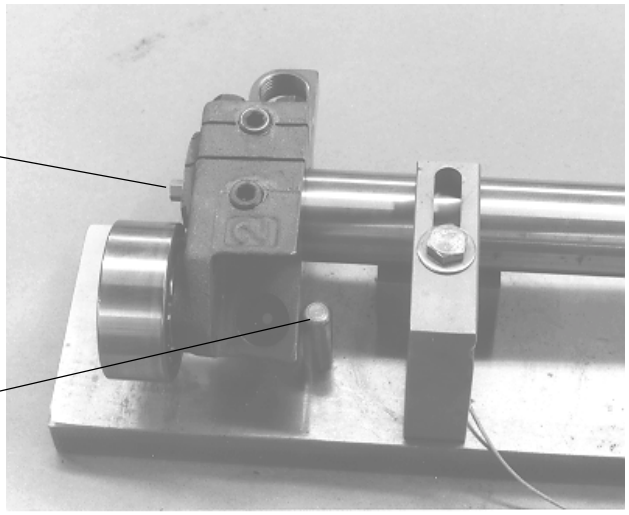
62H Quick Change Lever Shaft Alignment Fixture - 73H616



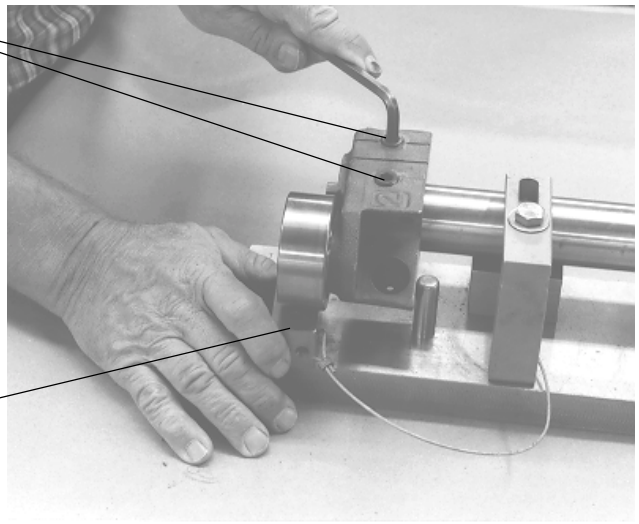
1. Assemble the Shaft, Cam Lever, Ball Bearing, Height Adjustment Screw and Seam Adjustment Screws.

2. Slide the Shaft through the splines on the fixture. Align the countersunk hole with the cone point clamp screw. Tighten the screw.

3. Tighten the clamp over the Shaft.



4. Adjust Height Adjustment Screw until the bottom of the Cam Lever makes contact with the dowel pin in the fixture. This is an initial endplay setting.



5. Adjust Seam Adjustment Screws until the gage block just slides under the Cam Roll (Ball Bearing).
   Use the block as a feeler gage.
   Tighten both Adjustment Screws securely.
   Check clearance.

8/4/97-06200003

Model 62H Seaming Lever Shaft Endplay Procedure

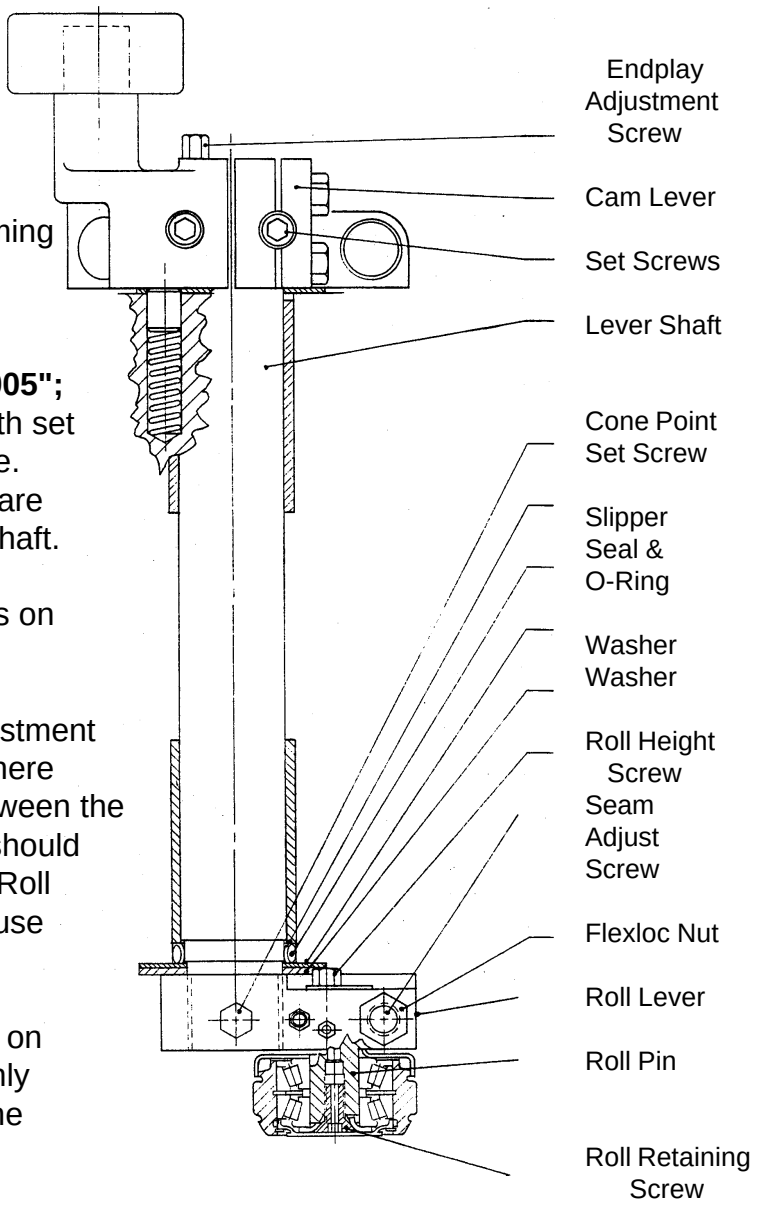
For machines equipped with Quick Change Seaming Roll Levers

Scope:

To correctly adjust vertical endplay between the Seaming Roll Lever and Seaming Cam Lever. This procedure is especially important when machines are equipped with the Quick Change Seaming Roll Levers.

Description:

This Procedure will explain and trouble shoot possible errors made during a Seaming Roll Lever change.



Follow the next few steps in order;

lst Install the Seaming Roll Lever with Seaming Roll and tighten the Seaming Roll Lever Cone Point Screw. Check endplay.

If Endplay was excessive or more than .005";

2nd. Use a 1/4" allen wrench to loosen both set screws in the Seaming Cam Lever above. Screw both set screws inward until they are finger tight against the Seaming Lever Shaft.

3rd. Loosen both 3/8 Hex. Hd. clamp bolts on the side of the Cam Lever.

4th. Adjust endplay using the Height Adjustment Screw in the Seaming Cam Lever until there is .002" to .005" (maximum) endplay between the Seaming Cam Lever and Turret. There should be NO clearance between the Seaming Roll Lever and the bottom of the Turret because of the Lift Plug and Spring above.

5th. Tighten both 3/8 Hex. Hd. Clamp Bolts on the side of the Cam Lever and then evenly tighten both Set Screws on the face of the Lever.

If initial endplay was found to be tight or absent;

6th. Loosen the Cone Point Set Screw in the Seaming Roll Lever.

continued next page;

7th. Follow steps 2 and 3. Then turn the Height Adjustment Screw counterclockwise to provide clearance. Tighten the Seaming Roll Lever Cone Point Set Screw.

8th. Continue with steps 4 and 5.

CAUTION:
When adjusting Seaming Rolls inward or outward to achieve seam specifications, always make final adjustments while turning the Seaming Roll Adjustment Screw clockwise. Never loosen or back off the Flexloc Nut more than it takes to turn the Adjustment Screw. Always hold the Seam Adjustment Screw in position while tightening the Flexloc Nut.

Trouble Shoot the Setup

Symptom	Probable Cause	Remedy
Lost end play	Height adjustment screw left loose in the Cam Lever	Follow steps 2 to 5.
	Thrust or Wear Washers changed during setup	Always use the same Thrust Washers when changing Levers.
	Clamp Screws or Set Screws left loose.	Follow steps 2 to 5.
Lost Seam Setting	Cam Lever Set Screws loosened out of sequence as described in steps 2 & 3.	Follow steps 2 & 3 and Reset seam adjustment
	Seam Adjustment Screw Flexloc Nut left loose.	Reset seam and tighten Nut.
	Flexoc nut did not pull Adjustment Screw tight leaving a gap behind the screw head on the back side of the Lever.	Loosen the Nut enough to turn the Adjustment Screw until the head of the screw bottoms out against the back of the Lever.
	Seam adjustment made while turning the screw counterclockwise.	Always make final seam adjustments while turning the Adjustment Screw clockwise.

Warning: If change overs are constantly requiring resetting seams or endplay, Seaming Lever Shaft and Cam Levers should be removed and reset using Fixture 73H616 as out lined on the following Assembly Procedures. This properly set Cam Levers prior to setting seams.

Model 61H & 62H Seamer

Belt Topper

Attachment

A basic guideline for repair or overhaul
Use drawing #D-29214

Angelus Model 61 & 62H
Belt Topper

Use Drawing no. 29214 and Part List 61HD4 & 62HD30

NOTE:
During a complete overhaul of this unit, it is recommended to replace all Ball Bearings, Oil Seals, Oilite Bushings and Thrust Washers.

Assembly Breakdown

1. Remove Topper Drive Case Cover.

2. Release taper lock bushings within Belt Drive Pulleys to remove Drive Belt.
   Check Drive Belt for cracks, frayed edges, or stretching. Replace if any of these symptoms exist.
   Check Drive Pulleys for abnormal wear of cogs due to excessively worn belt.

3. Remove hardware that secures Topper Drive Case to the Drive Bracket and Flange Bearing to Drive Case. Lift Topper Drive Case away from the Seamer.
   Replace all Ball Bearings, Bushings and Seals.
   Check fit of Key 23L647 and keyway of Drive Sleeve.
   Check Taperlock Bushing fit against the Drive Sleeve.

4. Remove hardware from the Topper Drive Bracket and lift out of Seamer Dr. Case.
   Replace Bearings, Oil Seal and Seal Sleeve.
   Check tooth wear of Topper Drive Pinion.
   Check Pinion and Drive Shaft key fit.

Assemble the Topper Drive Bracket and Drive Case.

Install Drive Gear w/ woodruff key, Ball Bearings, Spacers and Retaining Rings.
Press Oil Seal in with the open side facing down.
Use a liquid gasket material (Permatex sealant) on mating surfaces. Place the Drive Case into position and install hardware.
Assemble Topper Drive Belt and Pulleys within the Drive Case. Install the Take Up Roll. Leave the Cover off until Timing has been completed.

NOTE:
Disassemble Topper Gear Case while mounted to the Seamer for ease of access.

5. Remove Hardware from Gear Case Cover and disassemble Topper Gear Case.
   Replace all Ball Bearings, Oil Seals and Bushings.
   Check Tooth wear between Bevel Pinion and Bevel Gear.

   Check Topper Belt Drive Shaft for Bushing steps or excessive Oil Seal grooves.
   Assemble the Topper Gear Case components as layed out in the assembly drawing. Bevel Pinion and Gear should have approximately .003 to .005 of an inch backlash between teeth. Be certain that Oil Seal 39L815 is installed with the open side facing toward the Gear Case.
   Install Gear Case Cover using Gasket 29H615 and fill with Aero-Shell Grade 80 oil to the center of the sight glass.

6. Remove and inspect Belt Topper Cups with inserts, Topper Belt and Belt Pulleys.
   Check Pulleys for rounded edges or severe gouges.
   Check condition of the Topper Belt. Frayed edges, cracks, or tears are signs of wear and should be replaced.

7. Replace Oilite Bushings in the Topper Support Bracket.

NOTE:
The Topper Support Bracket may have to be removed to press out Bushings.

   Assemble Topper Belt Pulleys w/tension Spring 8H640, Topper Belt w/ Cups & Inserts.
   Check the assembly print to insure that all parts have been correctly installed and run freely without excessive friction.

8. Timing the Belt Topper.

   Initial timing is accomplished through initial alignment of Drive Belt and Pulley cogs and finally set through use of the Timing Belt Driven Pulley 10H630 w/ Taper Lock Bushing.
   Use the Handwheel on the Seamer to bring a couple of cans in under the Topper unit.

As the can progresses, align the Cup over the can opening.

The Driven Pulley located inside the Topper Drive Case is assembled with a taper Lock Bushing that clamps against the Drive Shaft Sleeve.

When satisfied with the location of cups versus containers, secure the Taper Lock Bushing against the Drive Sleeve.

Check Timing of cups while under the normal production speed of the Seamer. Acceleration may delay or advance timing slightly. Make finer adjustments where necessary.

NOTE:
Install all Guards and/or Safety equipment before production startup.

Model 62H Seamer Retrofitting the Oil Filtration & Recirculation Systems and Modifications to add Internal Air Pressure Components.

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62H Seamer Internal Pressure System Function & Seamer Preparation 3

Housing Service Cover Modification 5
Parts List 62HM21
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Housing Service Cover Replacement ..... Parts List 62HM26
Data Sheet G62.25-A

Upper Turret Housing Steam Seal Modification ..... Data Sheet G61.116

Lower Turret Guard Modification 5
Parts List 62HM22

Discharge Table Update ..... Parts List 62HM17
Data Sheet G61.134

Base & Upper Turret Housing Air Pressure Modifications ..... Parts List 62HM20
Data Sheet G62.13

Oil Filtration & Recirculation System Installation Process 6

Hydra Tech Operator Instructions & Layouts (Filtration Unit)

Model 62H Seamer Internal Pressure System

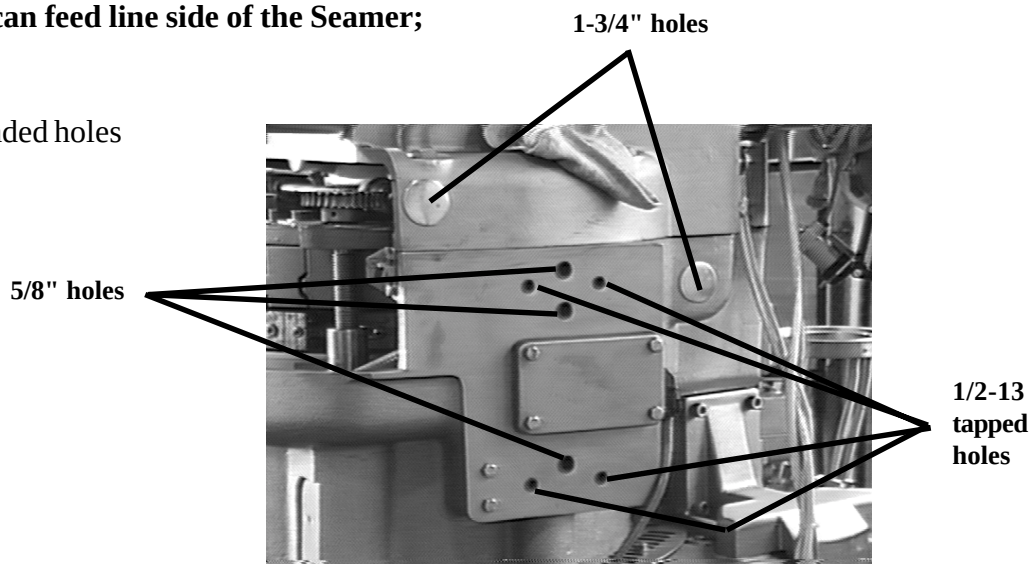
Function: Pressurized air is induced into the Seamer to keep water, contaminants or steam from from entering enclosed gear cases or housings. This is especially important where Oil Filtration & Recirculation units are incorporated. Increasing internal atmospheric pressure of the enclosed areas will keep out condensation that can accummulate after the Seamer cools down or water that can enter during wash down. 2 to 3 P.S.I. Dry Filtered Air is required to override atmospheric pressure.

To prepare the Seamer for the Pressurization System,
there are areas that must be plugged or setup with fittings.

Close off the following points around the Seamer using capscrews, pipe plugs or plastic cap plugs.

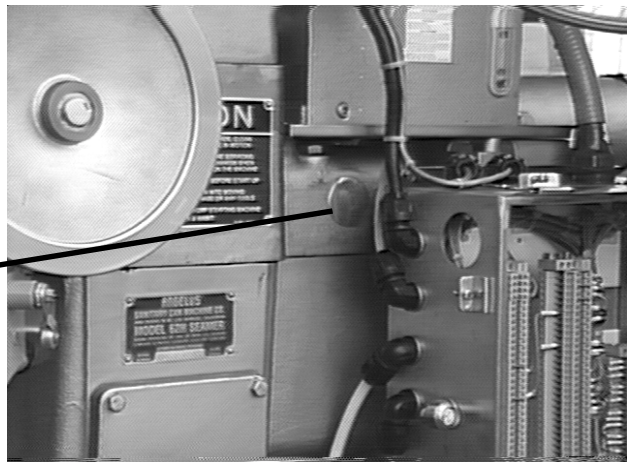
The Front or can feed line side of the Seamer;

(3) 5/8 holes
(4) 1/2-13 threaded holes
(2) 1-3/4 holes



Cover Feed side;

(1) 1-3/4 hole



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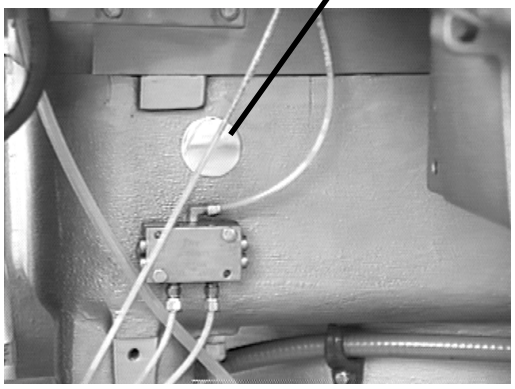
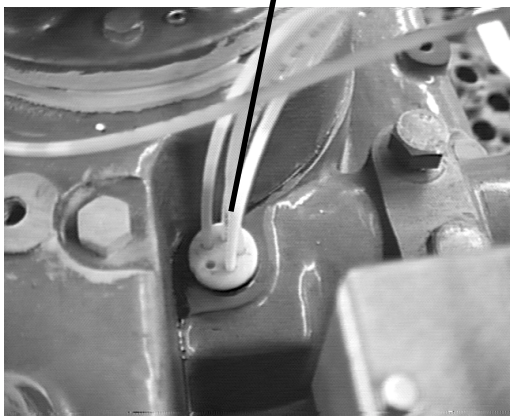
Back of the Seamer;

(1) 1-3/4 hole in the Drive Case



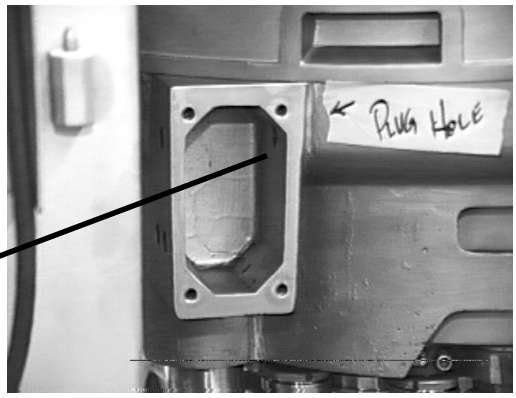
Check the Lubrication Line Grommet. A fifth hole, not used, should be plugged with a piece of 3/16" dia. nylon rod or equivalent.

Check the Upper Turret Housing drain line area. A second hole, not used, should be plugged with a 3/8-18 NPT plug.



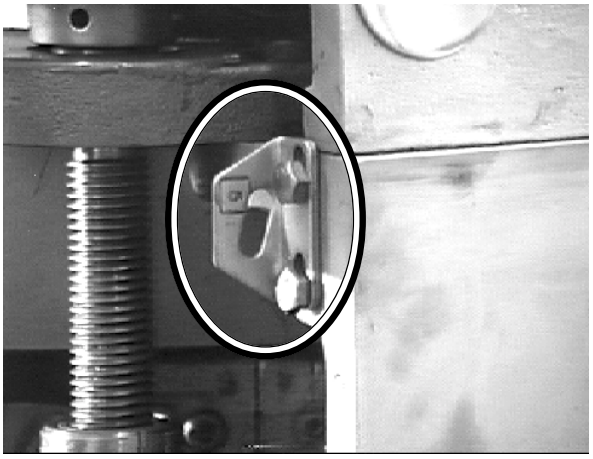
Discharge side;

(1) 1/2-14 NPT hole on the inside of the Remote Operator Station cavity on the Upper Turret Housing.

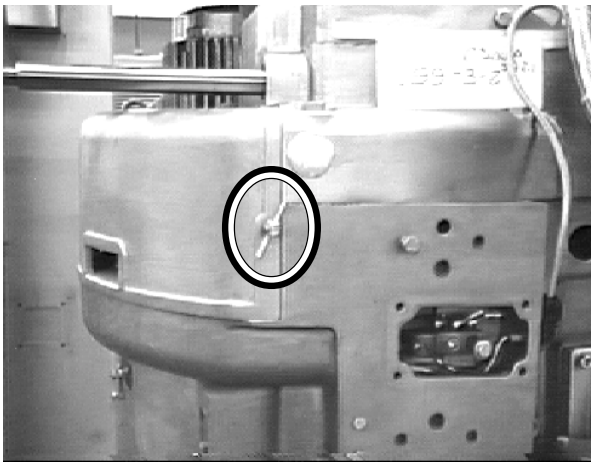


The following updates are recommended;

Data Sheet G62.14 & Parts List 62HM21 deals with updating the Housing Service Cover to include latches and thumb screws replacing the magnets. Thumb Screws pull the Service Cover against the Upper Turret Housing and Drive Case surfaces.

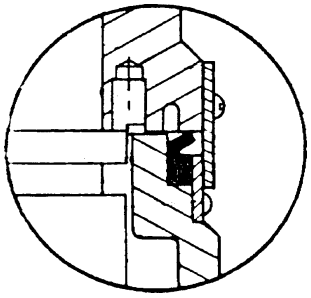


Latch modification attached to the Upper Turret Housing.

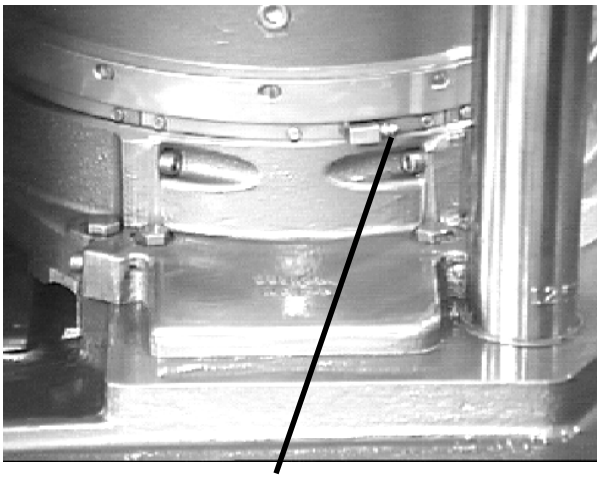


Thumb Screw in the Service Cover.

Data Sheet no. G62.16 & Parts List 62HM22 will update the Lower Turret Guard, V-Ring Seal, Shield and add a grease fitting to insure that the V-Ring is lubricated during Seamer operation.



Lower Turret Guard modification with the addition of a V-Ring Seal & Shield.
A grease fitting provides lubrication for the seal.



Grease Fitting

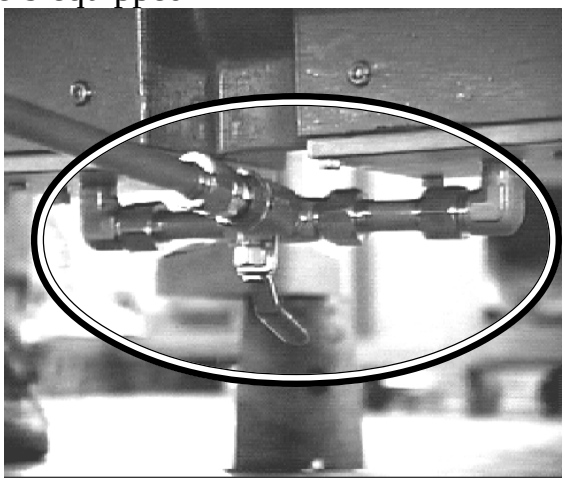
Data Sheet G61.116 updates the Upper Turret Housing Plastic Steam Seal adding a plastic block up front that holds the strip in place more securely.
Data Sheet no. G61.134 & Parts List 62HM17 provides parts and modifcation information to enclose the Discharge Table Assembly or see Chapter 5 in the 61H 62H Service Manual.
Data Sheet no. G62.13 & Parts List 62HM20 provides information for attaching air lines to the Seamer.

2/17/96-06200005

Oil Filtration & Recirculation System Installation Process.

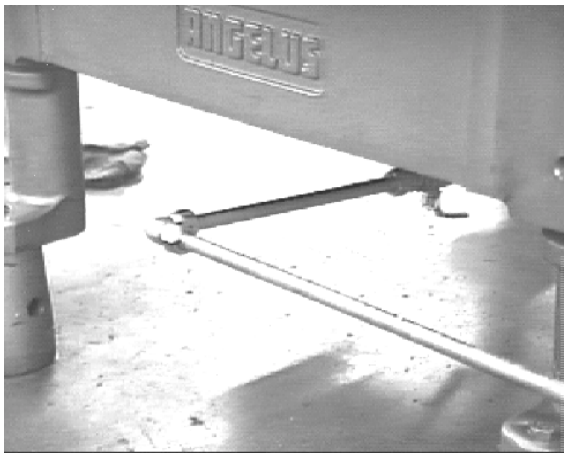
In Field Retrofit or for Installation of new Seamers equipped with the optional Filtration System.
Use Angelus Data Sheets and supplier information following these instructions.

1st. Mount the Filtration Enclosure 4 to 5 feet away from the Base Housing ball valve under the machine. Limit the number of tube bends or angled fittings. The more fittings or bends there are will require mounting the Enclosure closer to the seamer.



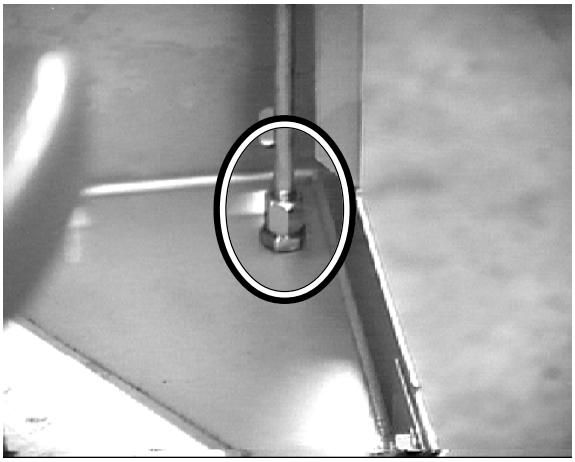
Base Housing drain fittings and ball valve supplied on all machines.

NOTE: Maximum mounting distances are required to maintain a minimum vacuum reading during operation. Numerous bends or fittings will increase the vacuum level in the system. When mounting the enclosure further than recommended distances, additional components may be required. Follow the Floor Plan layout supplied with every Seamer.



Limit the amount of bends or fittings in the suction line.

2nd. Install 1/2" tube bulkhead fitting to the lower right hand side of the Seamer Enclosure on the cover feed side of the seamer.
This fitting should be 37^0 flared and all stainless steel.

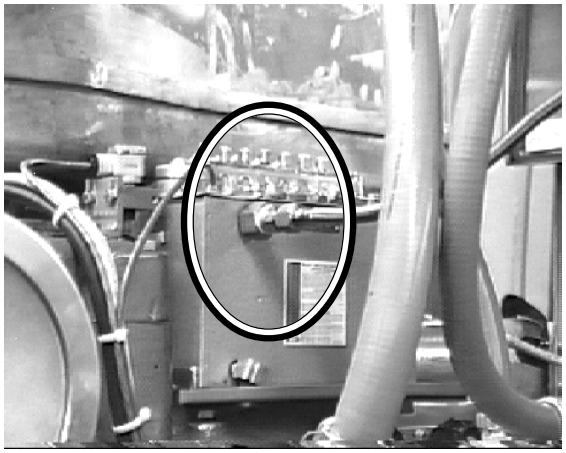


3. Install a length of 1/2" tubing from the bulkhead fitting up to the same level as the 7 Feed Lubricator refill fiting.

4. Secure the 1/2" tubing length using the bracket supplied. Bolt the bracket to the Enclosure wall.

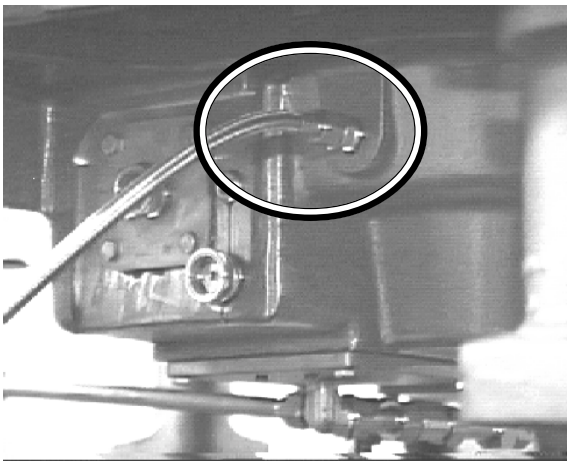
5. Remove the 3/4" hole plug from the side of the 7 Feed Lubricator. This may require removing a couple of the oil pumps from this end of the Lubricator to get inside the reservoir.

NOTE: If there is no predrilled hole in the Lubricator reservoir, the Lubricator must be removed if drilling is required. An easier solution is to punch a 3/4" hole using a 3/4" sheet metal knockout fixture. A pilot hole must be drilled first and care must be taken to keep chips from entering the reservoir.
(Knockouts are used frequently in the electrical trade on control panels and cut a clean hole limiting metal chips from entering the reservoir.)

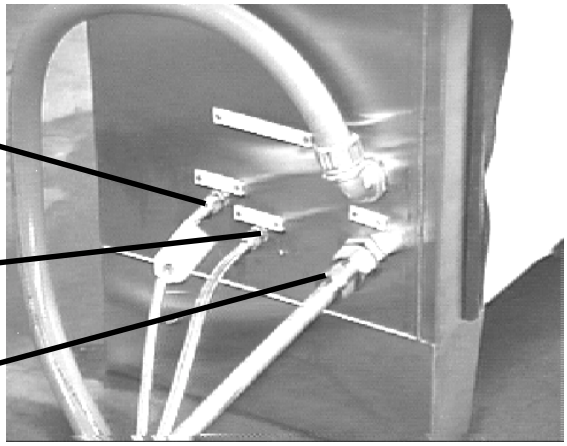


Lubricator refill fitting and flex line installation.

6. Install the male connector, O-Ring, nut and flex line connecting the opposite end of the flex line to the 1/2" tube fitting installed against the enclosure corner.



7. Remove the pipe plug from the Base Housing and install the fitting and 1/2" stainless steel tube from the Filtration System enclosure for returning the oil to the Housing.



8. Connect the Lubricator *1/2" refill tube from the bulkhead fitting under the corner of the enclosure over to the top fitting on the Lube Panel.

   Connect the Base Housing return (*1/2" tube) to the lower fitting on the panel.

   Install the *1" suction line tubing at this location.

continued next page;

*Earlier machines where equipped with 3/4" stainless steel tube suction lines from the factory in which were changed later to 1" tubes and fittings.
These figures depict the use of flexible hoses leading from the enclosure to the seamer. These are used during the system setup at the factory and are not suggested for use in the field.

Retrofit Instructions continued;

9. Install *Electrical components as required. System requirements are as follows;

   A. The Filtration System should be programmed to run continuously as long as the power to the Seamer main control panel is "ON".

   B. The 7 Feed Lubricator refill should be programmed based on the High/Low Oil Level Sensor in the Lubricator reservoir. When the oil level reaches the Low Oil Level side of the sensor, oil feed from the Base Return line should be programmed to divert oil up to the Lubricator reservoir until the High Oil Level side of the sensor switches oil feed back to the Base Housing. This is accomplished through a solenoid built into the Filtration System enclosure.

10. "Lube Fail" features should be programmed to shut down the Seamer in the event that the Filtration system has shut down due to an overload in the pump motor.

   A. Due to High pressure situation, normally related to plugged or restricted filters requiring change in which a blinking indicator would warn the operator. This same situation should allow the Seamer to continue running for a specified length of time (30 minutes maximum) until filters can be changed out or coast stop the seamer. This is controlled through a High Pressure switch located in the Filtration Enclosure.

   B. Due to a Low Pressure situation in which a blinking indicator would warn the operator. This situation is controlled by a Low Pressure switch located in the Filtration enclosure.

   C. Due to a Low Oil Flow situation as a result of a restriction in the suction line caused by contaminants, lack of oil etc;

*Electrical components required will depend upon existing controls within the main control panel. Contact the Customer Service Department before ordering electrical components for your seamer. Programming fail safe systems into the Filtration Unit should include the above situations to protect the Seamer against failure. Seamers supplied with Filtration systems should have programs installed prior to shipment. Changes made to existing factory programs should not delete or interfer with fail safes built in to protect the Seamer. Always refer to the Parts List & Instructions information when working with these components.

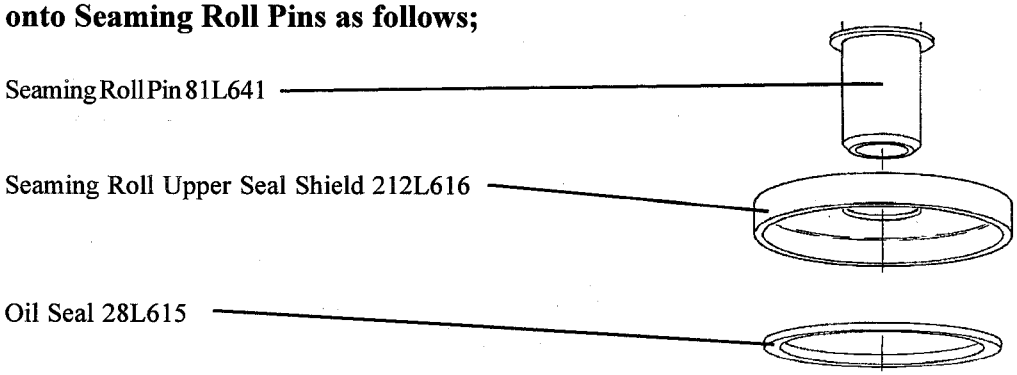
8/31/04-06200006

Model 61H and 62H Seaming Rolls with Ceramic Ball Bearing Assembly Installation Requirements

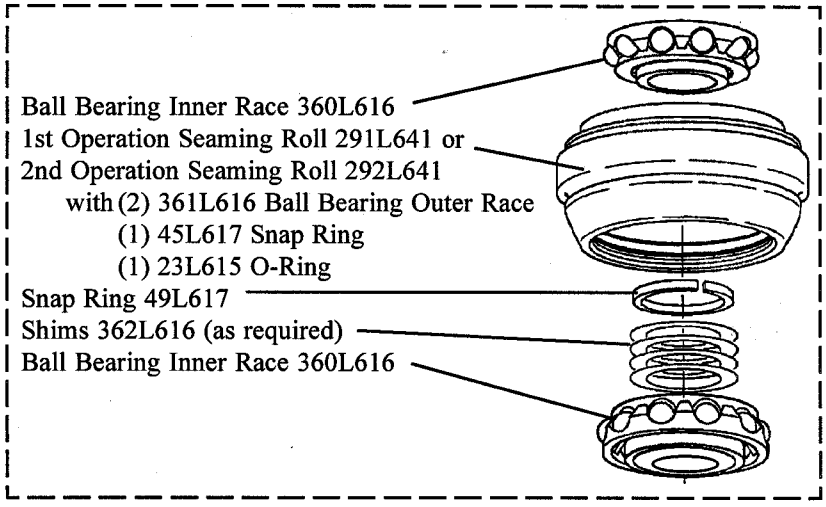
Seaming Roll with Ceramic Bearing Assembly
Installation sequence for 61 & 62H Seamers

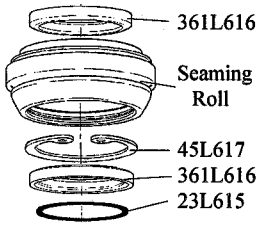
NOTE: Seaming Rolls with Ceramic Ball Bearings are shimmed at the factory for proper running clearance before shipment. Install Seaming Roll Assemblies as packaged for shipment. Do not mix or re-arrange assembly components.

Install Seaming Roll components onto Seaming Roll Pins as follows;

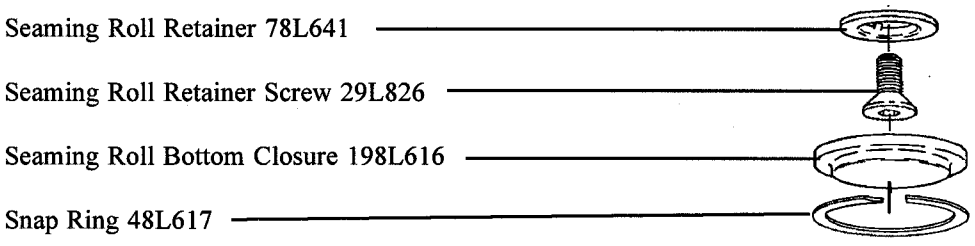


Pre-shimmed Seaming Roll with Ceramic Bearings


Ball Bearing Inner Race 360L616
1st Operation Seaming Roll 291L641 or
2nd Operation Seaming Roll 292L641
with (2) 361L616 Ball Bearing Outer Race
(1) 45L617 Snap Ring
(1) 23L615 O-Ring
Snap Ring 49L617
Shims 362L616 (as required)
Ball Bearing Inner Race 360L616



Seaming Roll parts installed prior to assembly


Seaming Roll Retainer 78L641
Seaming Roll Retainer Screw 29L826
Seaming Roll Bottom Closure 198L616
Snap Ring 48L617

LUBRICATION REQUIREMENTS: Ceramic Ball Bearings assembled within the Seaming Roll and mounted ready for production, should only require **one shot** of grease from a hand grease gun for each assembly. If more than **one shot** of grease is installed, the ceramic ball bearing will expel excess grease out of the assembly.

Suggested lubrication intervals = every 72 hours w/ N.L.G.I. Type O grease or 1 shot of grease after sanitation to remove water from the Seaming Roll.

Hydra-Tech Filtration System Changes over the last year.

Original System with the upright

Flow switch

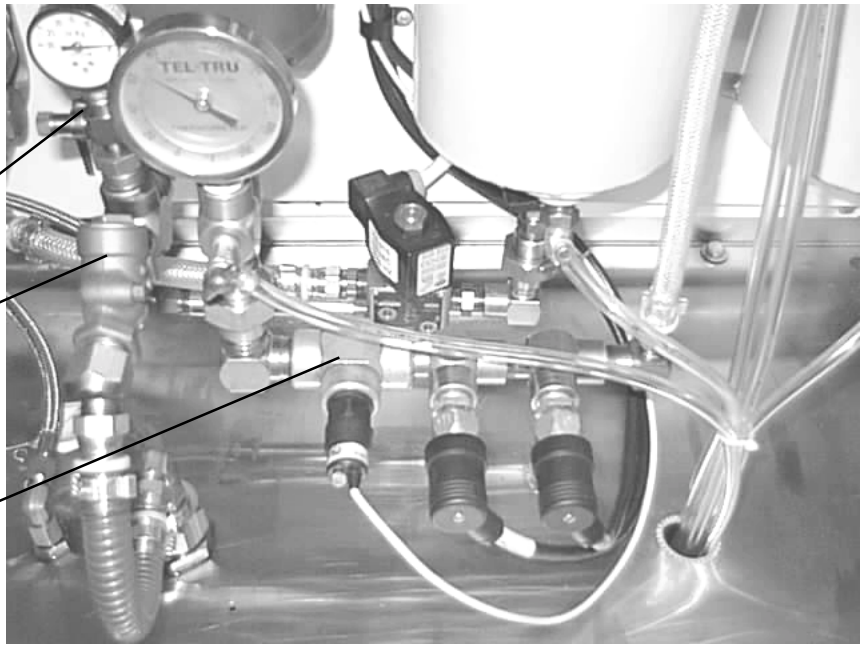
and

Wye Strainer

System later was changed to include;

Vacuum Gauge
Bleed Cock and
A Check Valve

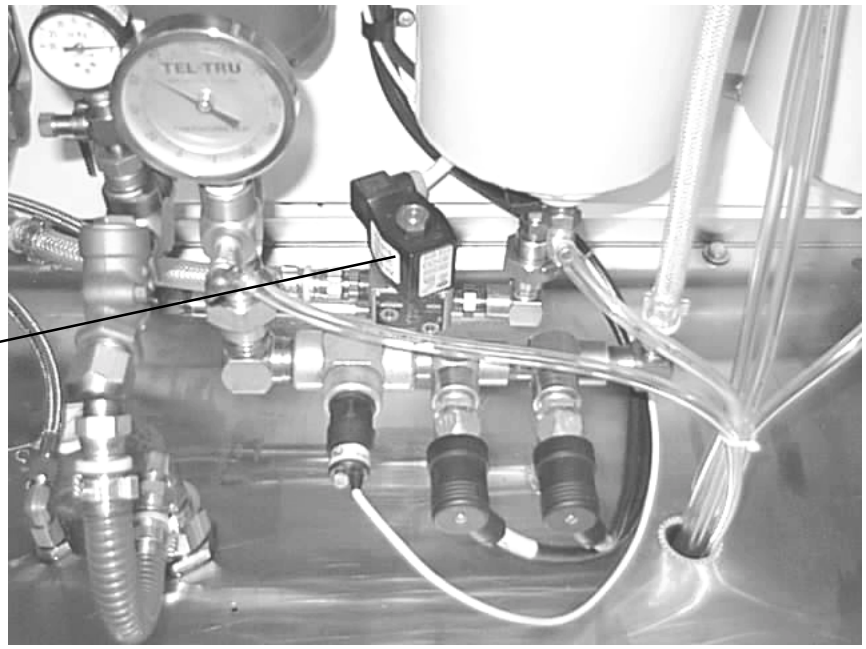
horizontally mounted
Flow Sensor
(not susceptible to air bubbles)



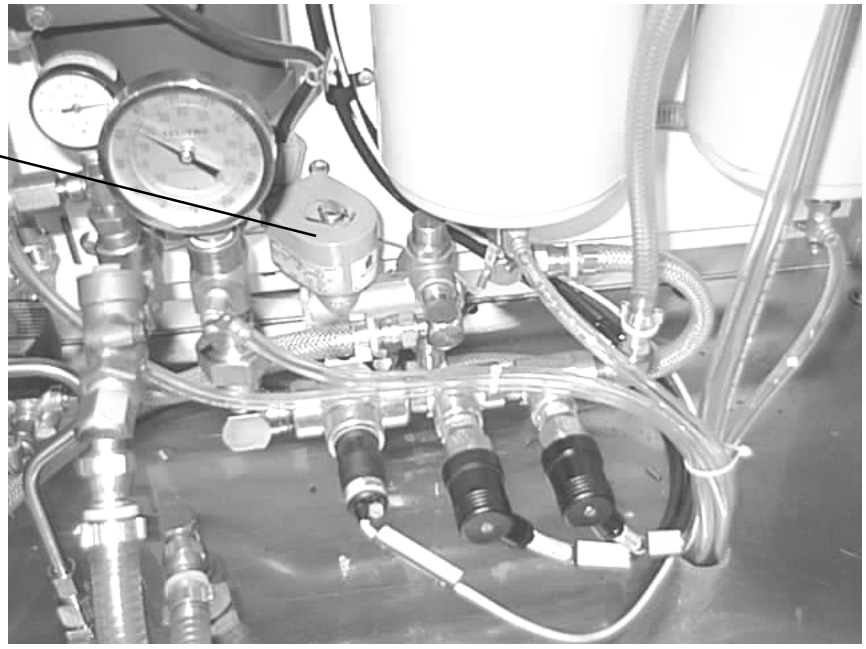
Hydra-Tech Filtration System Changes over the last year.

Another change made within the Year;

The Solenoid Valve originally installed had a small orifice opening creating higher pressures.

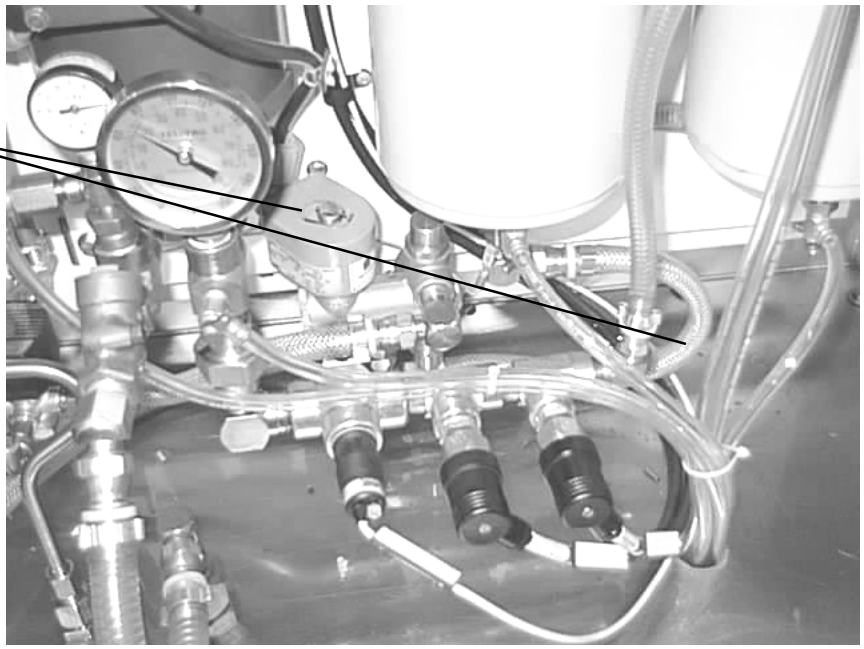


The Solenoid Valve was changed to a larger Valve and orifice opening that included the addition of 1/2 hose connections.

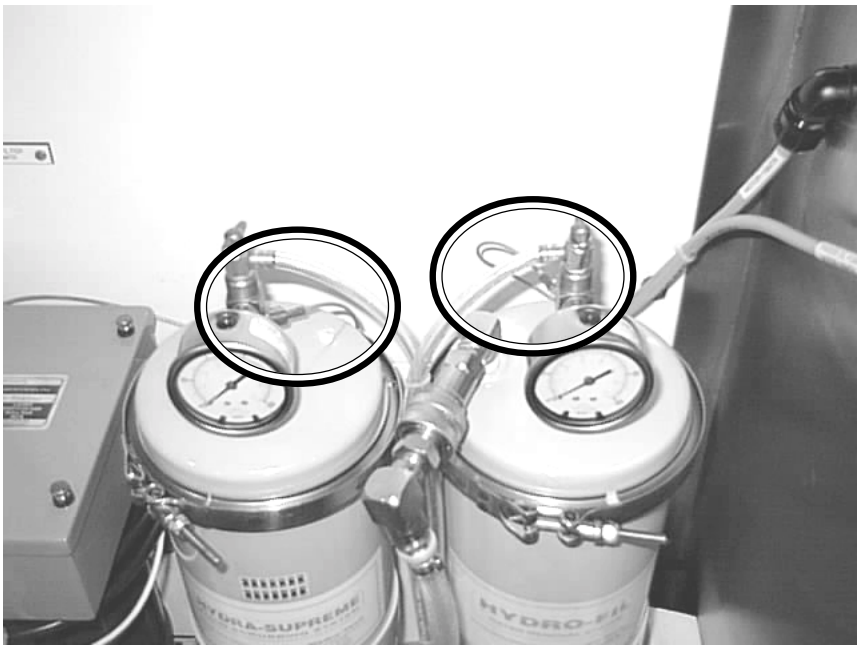


Hydra-Tech Filtration System Changes over the last year.

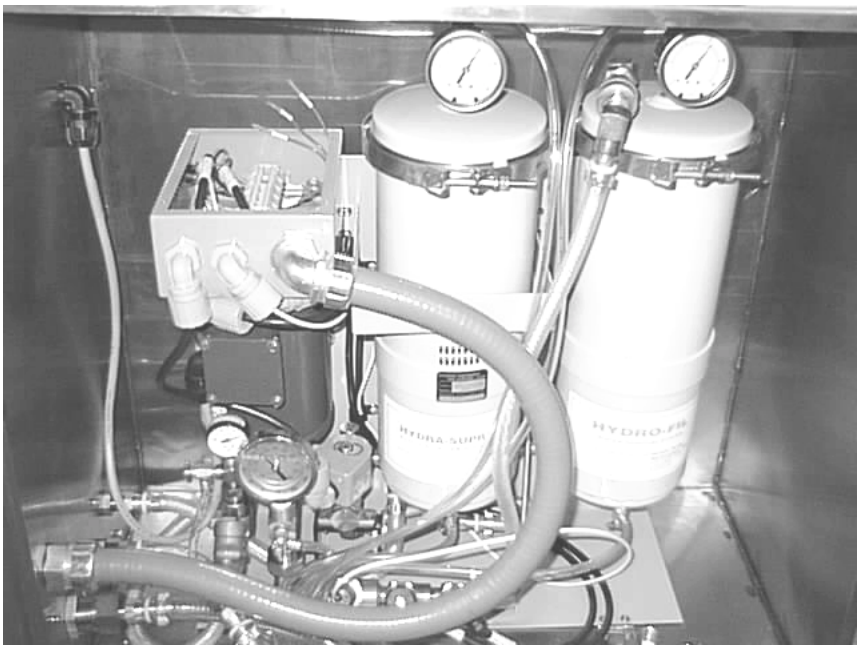
The Solenoid Valve and Hose change led to another problem of static electricity buildup in the cannisters during operation.
This has been measured up to 600 VDC.



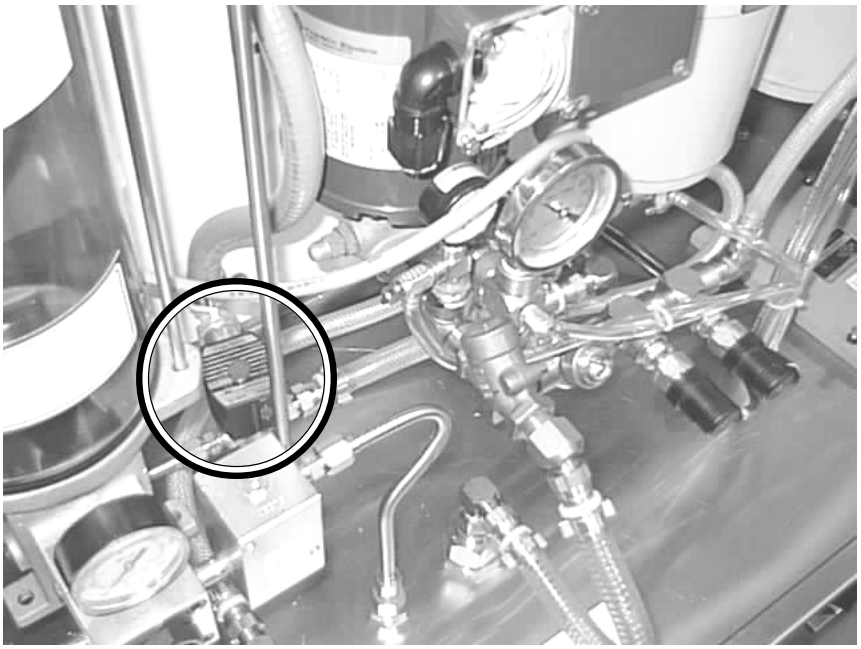
A temperary fix was to include the Grounding Straps supplied by Hydra-Tech which will later be replaced with a steel woven hose to discharge the electrical buildup.



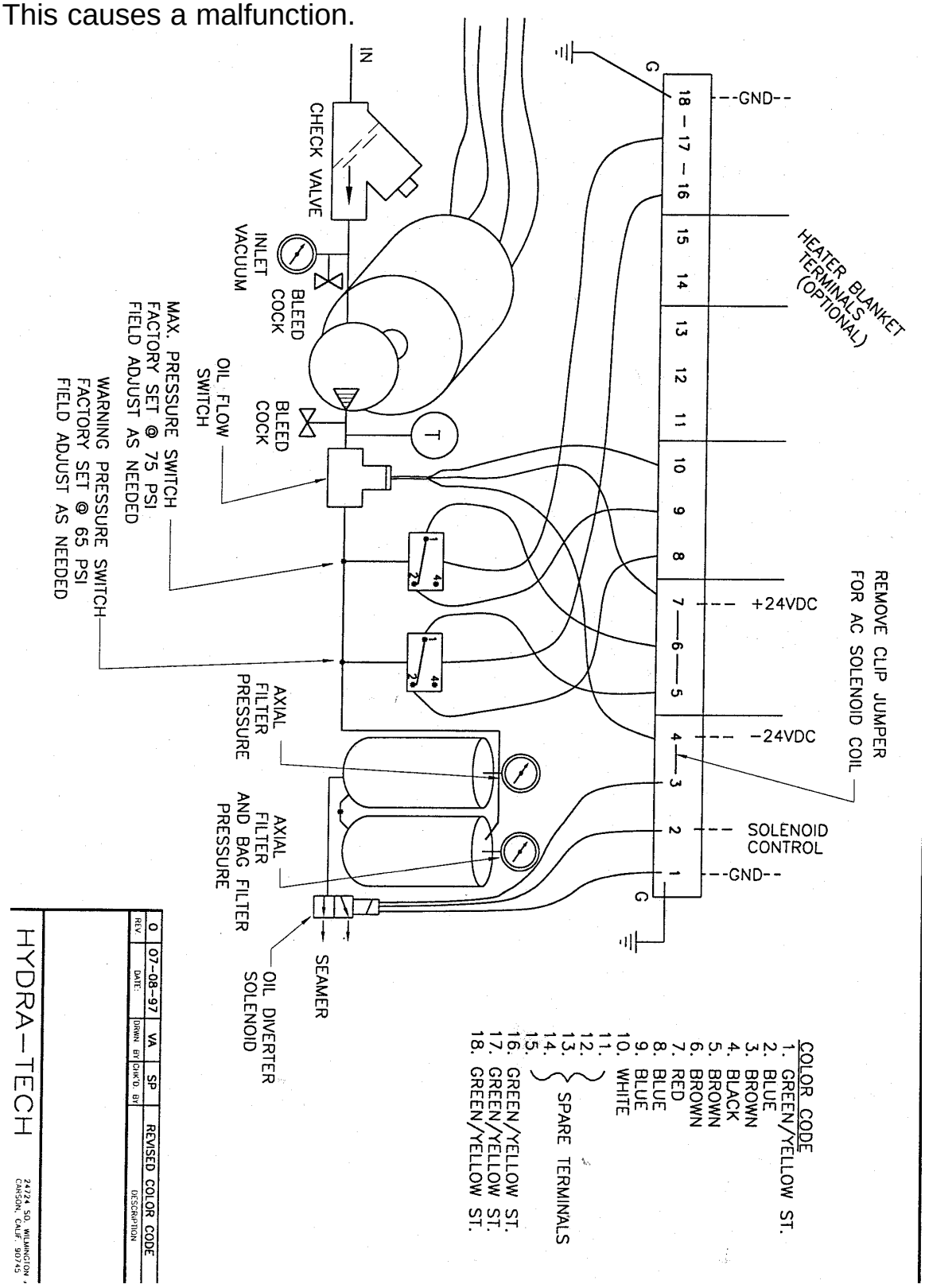
62H Machine ABES/PT Giant installed with the need to ground the system. The 62H has four enclosures on the floor that are all different in the assembly.



121L Systems have been installed using a Solenoid Valve 4S439 that was replaced on the 140S machine because of malfunction.
The replacement solenoid was changed to a 51S839



Latest change has been wires 4 and 7 connected backwards on the Flow Sensor. This causes a malfunction.



Model 62H Seamers

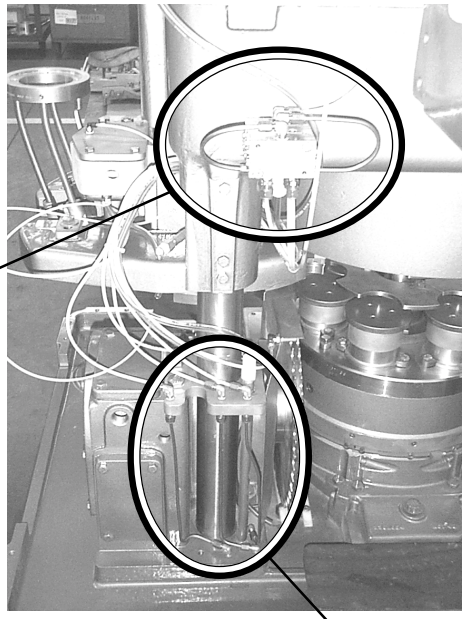
Subject:
7 Feed Lubricator Oil Line Splitter.
Rigid Base Line Assembly.

Description:
A combination of three Splitter Valves have been installed to distribute oil from the number 6 lube line off the 7 Feed Lubricator. This one line splits off to lubricate the Lower Chuck Cam, Can Feed Chain, Discharge Idler Gear and Clutch and Timer Housing.
This conversion also incorporates the Rigid Base Line Assembly necessary to connect the additional four lines to the Base and designated areas.

Splitter Retro-Fit Procedure;
Parts list:

Item #	Qty.	Part #	Description
1	(3)	30H614	Divider Valve
2	(5)		3/16 tube x 1/8 P. SS Male Elbow
3	(4)		3/16 tube x 1/8 P. Male Connector
4	12"	114L614	3/16 SS tubing
5	12'	32L814	3/16 Nylo Flo tubing

Splitter Assembly
Consists of (3) 30H614 Divider Valves assembled together using (2) 1/4-20 x 4" Hex.Hd. Screws.
This assembly is mounted to the
Upper Turret Housing directly below the 7 Feed Lubricator .



Splitter Assembly

Rigid Base Line Retro Fit
Parts List:

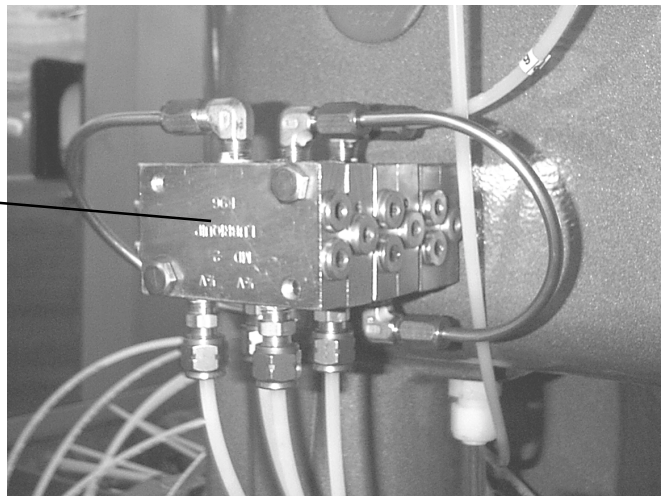
Item #	Qty.	Part #	Description
6	(1)	62L814	3/8" Tube Connector
7	(1)	32H614	Lube Line Support Bracket
8	48"	114L614	3/16 SS tube
9	(1)	60L814	Male connector
10	(4)		3/16 T x 1/8 P SS Male Connector
11	(4)		3/16 T x 1/8 P SS Male Elbow
12	(1)		1/2 NPT to 1/8 NPT male to Female Bushing

Rigid Lines

Model 62H Oil Line Splitter

Splitter Retro-Fit Procedure;

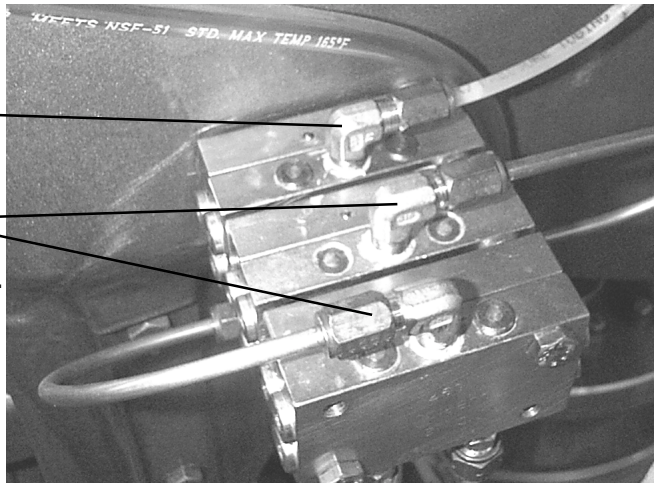
Mount the Divider Valve Assembly using 1/4" fasteners.



Install Splitter lines (top view)

Incoming #6 line from the 7 Feed Lubricator to this position.

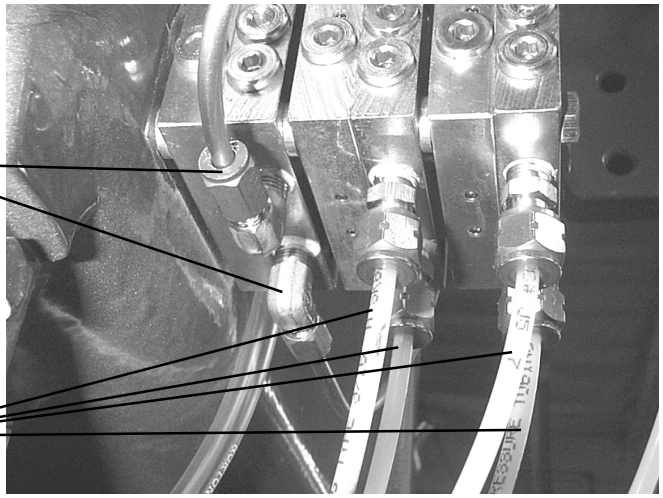
3/16 tube fittings and 3/16 SS tubing connecting all three Divider Valves. Bend 3/16 tubing to fit top and bottom fittings.



Splitter lines (bottom view)

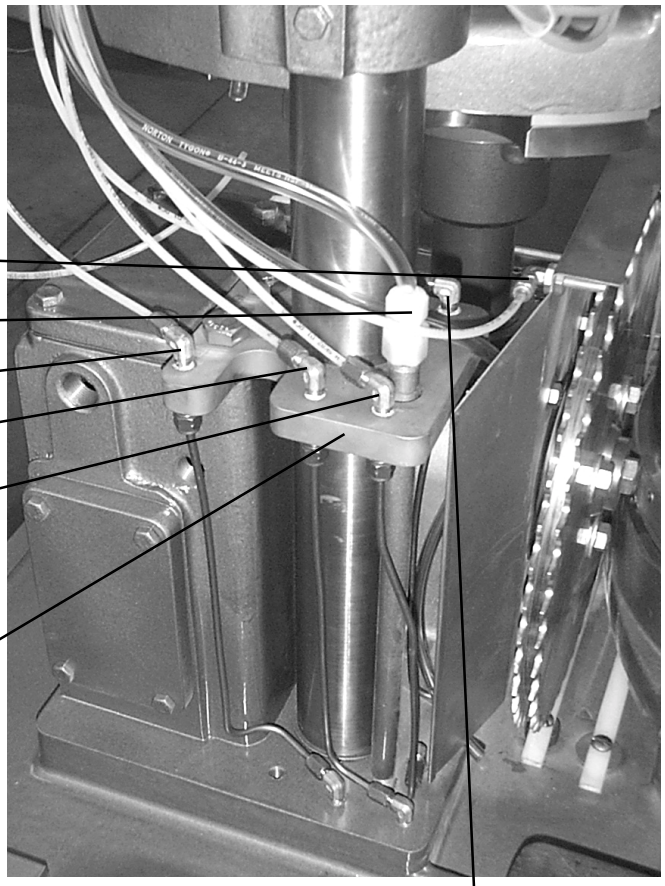
Both Outgoing 3/16 tube and fittings. (supplied by #6 Lubricator Line)

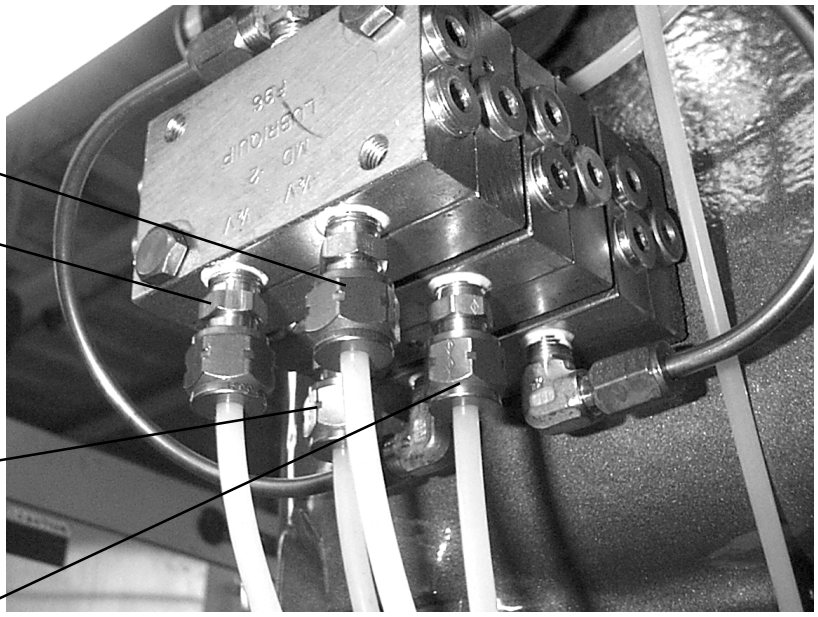
Four outgoing 3/16 fittings and 3/16 Nylo Flo tubing to destinations.



Rigid Base Lines
Rigid Base Lines are installed to strengthen the assembly from line breakage due to loose cans and ends.

Line Destinations

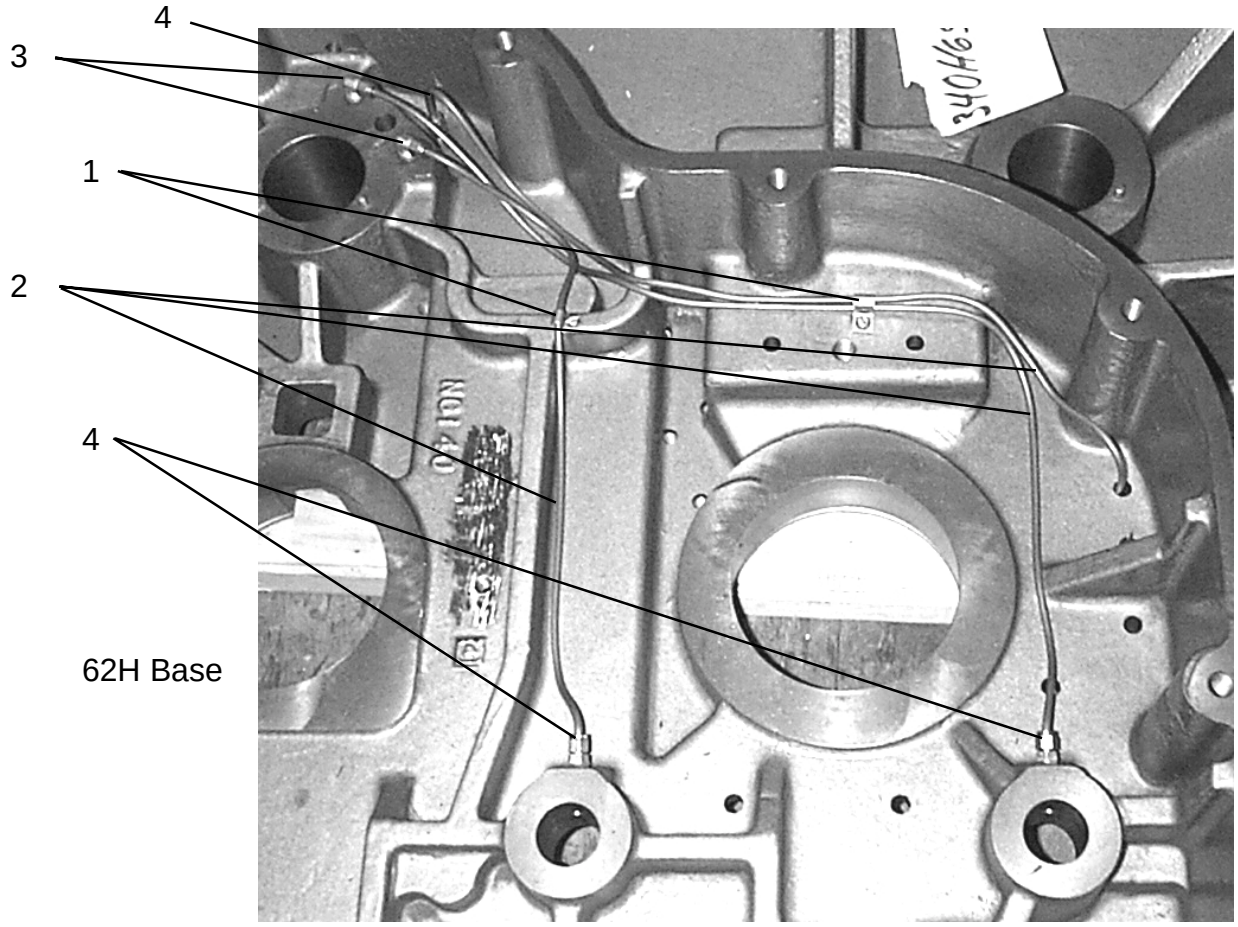




Rigid Base Lines
Base lines required.
Discharge Idler Gear
Lower Chuck Cam
Intermediate Gear

Parts List:

Item #	Part #	Qty.	Description
1	23S814	(2)	Tube Clips
2			3/16 copper tubing
3		(2)	3/16 T x 1/8 P. Elbow #69F
4		(3)	3/16 T x 1/8 P. Male Connector



Model 62H
Operator Station Instructions

Equipped with the
Computer Technology Corporation
(CTC) System.

Operator Station Instructions

Main Power

Al. Turn on main power at the disconnect switch located at the upper right hand Corner of the Main Electrical Control Enclosure.

A2. Wait about twenty seconds for the PLC to go through a power up routine.

A3. Locate the Operator Station and the Computer Technology Corporation (CTC) - P1 power station on the left door at the cover feed side of the machine.

Control Power

B1. Turn the "Off - On" control power switch to the "On" position momentarily, then release it. The white selector switch light will be illuminated, indicating that power is on.

B2. Pull out all Emergency stop (E-Stop) push buttons. One E-Stop push button is located on the Operator Station, below the CTC and the other is on the opposite side of the Seamer enclosure, next to the motor guard.

Start-up Instructions

Cl. When control power is turned on, the CTC goes through a boot up routine for about thirty seconds.

C2. The CTC displays Panel- I after booting up. Panel- I is the first of eleven graphical operator interface control screens of the 62H operator interface program.

C3. When the CTC looses communication with the PLC, exclamation points (!) will be displayed on all panel tools. If this occurs, check the communication line and make sure the PLC processor is running.

Start-up Instructions

D 1. The Seamer is ready to run when the CTC Control Reset push button and the Control Reset push button pilot light on the Operator Station are both flashing. In the case where only the CTC Control Reset push button is blinking, it implies that Jam Faults Reset is required. Push the CTC "Control Reset" push button to reset Jam Faults. If the light continues to blink, push the "Go To Alarm Screen" push button to see possible Jam Faults.

D2. When safety stops are cleared, start the Seamer by pushing the "Control Reset" push button; wait for the alarm horn to sound at least once then push the "Seamer slow Speed" push button on the CTC. To stop the Seamer at any time, simply pus the "Stop Seamer" push button and the Seamer will coast to a stop.

Start-up Instructions

D3. Any abnormal condition that cause the Seamer to stop or that prevents the Seamer from starting is displayed on the Message display on Panel- I and is also logged on the Alarm screen. To view the next message on the Message display stack, push the "MSG-CLR' button. The "MSG-RST" push button resets all messages on the message display stack.

D4. To move through different screens, push "SELECT PANEL" button on Panel- I of the CTC screen. The panel selection screen (Panel- IO) will appear. Select a panel using the "Go To Panel " button.

Push Button Operation

El. Selector Switch "Off - Controls - On
This switch is used to turn on the control power. The white selector switch pilot light will illuminate when the control power is on.

E2. Push - Twist Release Palm button "Emergency Stop".
The normal state of this push button is when it is pulled (out). When pushed, the Seamer is in an emergency stop mode. The emergency stop pilot light (red) will be illuminated when the Seamer is in the emergency stop mode.

E3. Push - Pull push button "Filler Drive Clutch".
The Filler Drive Clutch is disengaged when this push button is pulled (out). The Seamer will run at this state, without moving the filler. For the Seamer to drive the filler, the Filler Drive Clutch Push - Pull button must be engaged and a solid amber light in the push button must be illuminated. A flashing amber light indicates that the Filler Drive Clutch is not properly engaged.

E4. Push Button "Control Reset".
If any of the safety devices on the Seamer is tripped, the CTC Control Reset push button will be blinking while the Control Reset push button pilot light on the Operator Station will stay off When all conditions to run are normal, both the CTC Control Reset push button and the Control Reset push button pilot light on the Operator Station will be flashing.

Graphical operator interface "CTC - PI Screens"

F1. If the CTC screen goes to screen saver mode, touch anywhere on the screen to reactivate. If the power station does not respond, reboot the system by turning the control power off and then on again.

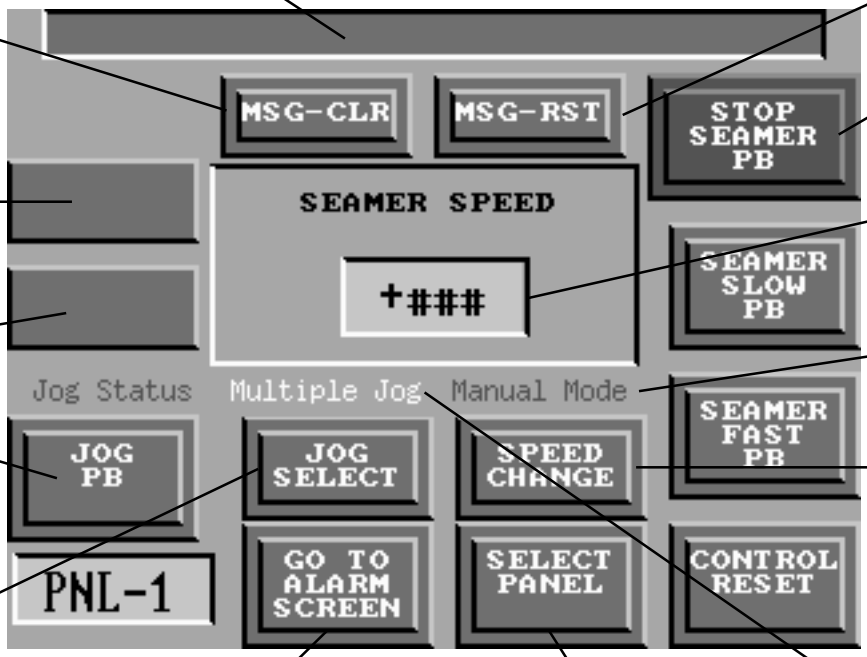
F2. For technical details of the CTC - PI powers station, refer to the product manual by Computer Technology Corporation, Telephone: #513-831-2340 and Internet: www.ctcusa.com

F3. See graphical operator interface control screen layouts attached for a basic description of the function of each panel tool.

Model 62H CTC Operator Instructions

Panel Explanation

Panel - 1



Message Display: Will display all fault conditions that stop the Seamer or that would prevent the Seamer from starting.

Message Clear Scrolls through messages on the message display stack one at a time.

Resets all inactive messages

Stops the Seamer

Wash Mode Run Mode Door Enable Indicator

Actual Seamer Speed display

Seamer Brake Indicator

Indicates Auto/ Manual Mode Status

Will Jog as long as only local Jog is selected

Will translate from Slow to Fast speed automatically when the customer auto speed signal is high

For Selecting Jog Mode at the CTC Operator Station

To see all Alarms, both active and inactive that has not been acknowledged

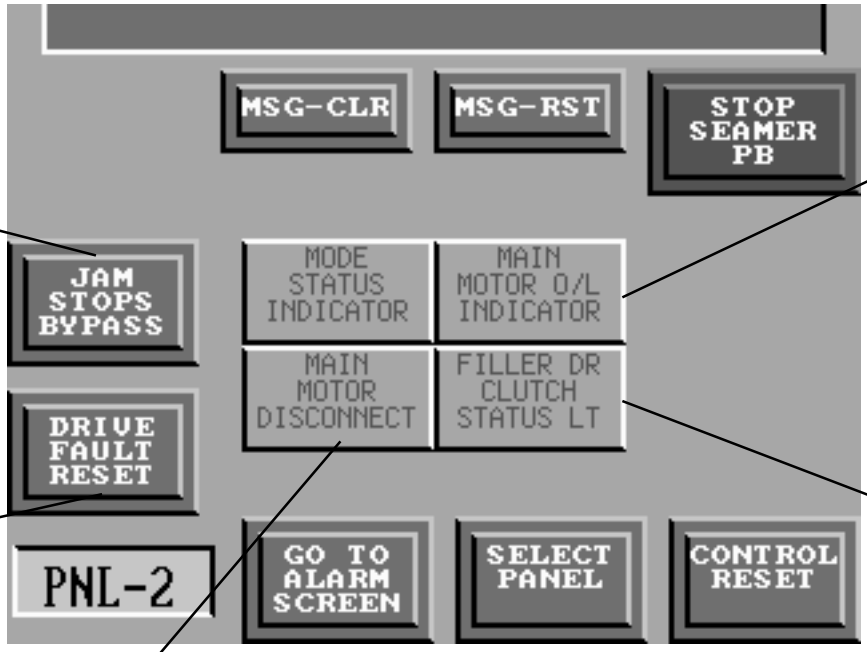
"Go to Panel" Selection Screen

Indicates which Jog station is ready for Jog

Model 62H CTC Operator Instructions

Panel Explanation

Panel - 2



Jam Stop Bypass Push Button allows the Seamer to run ignoring Jam Stop Stations.

Drive Fault Reset Clears or Resets minor inverter drive faults.

Indicator for Main Seamer Drive Motor Overload Fault

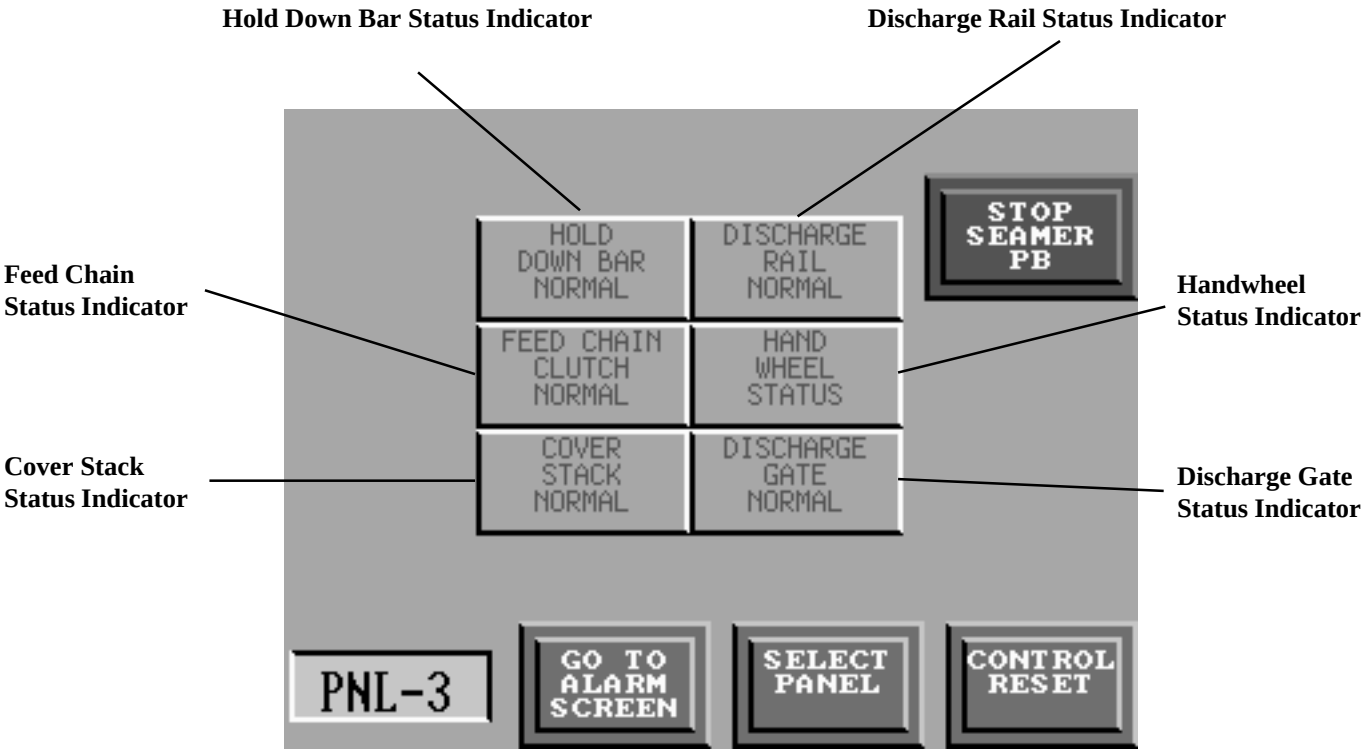
Indicates the Off status of the Filler Drive Seamer Safety Clutch

Indicates the status of the Main Motor Disconnect switch

Model 62H CTC Operator Instructions

Panel Explanation

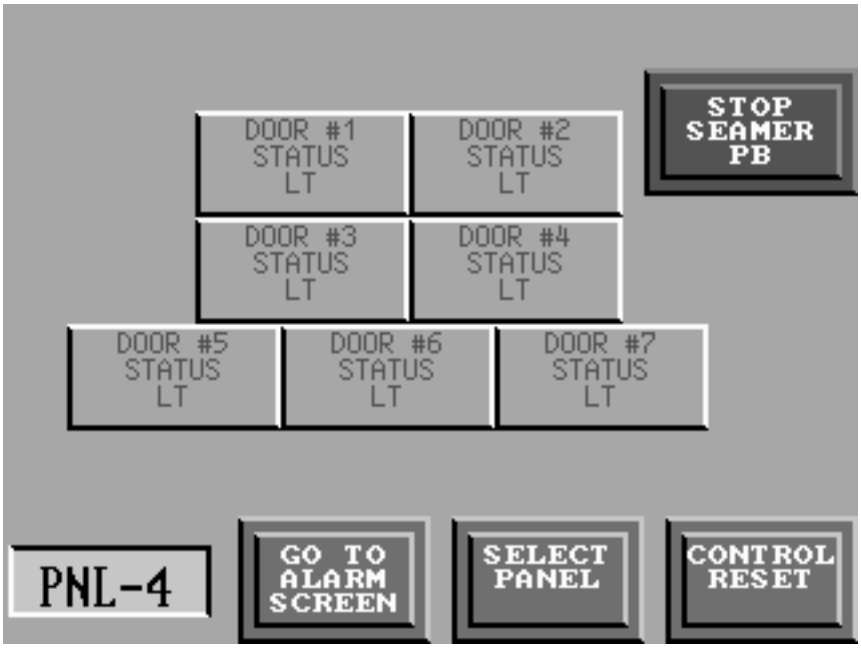
Panel - 3



Panel Explanation

Panel - 4

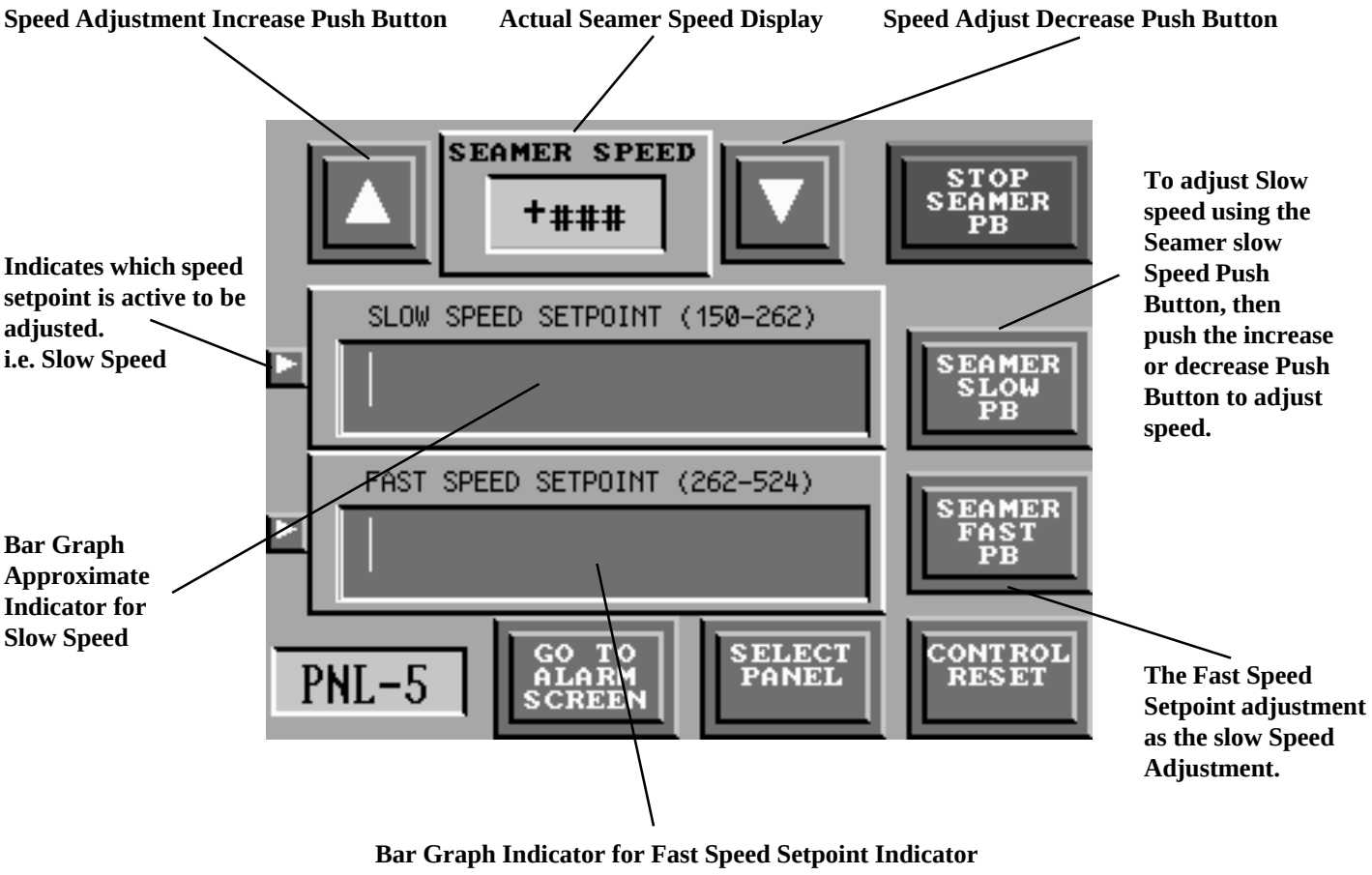
Indicators on this panel show the status of the Sound Enclosure Doors #1 through #7. Status = Door Open



Model 62H CTC Operator Instructions

Panel Explanation

Panel - 5

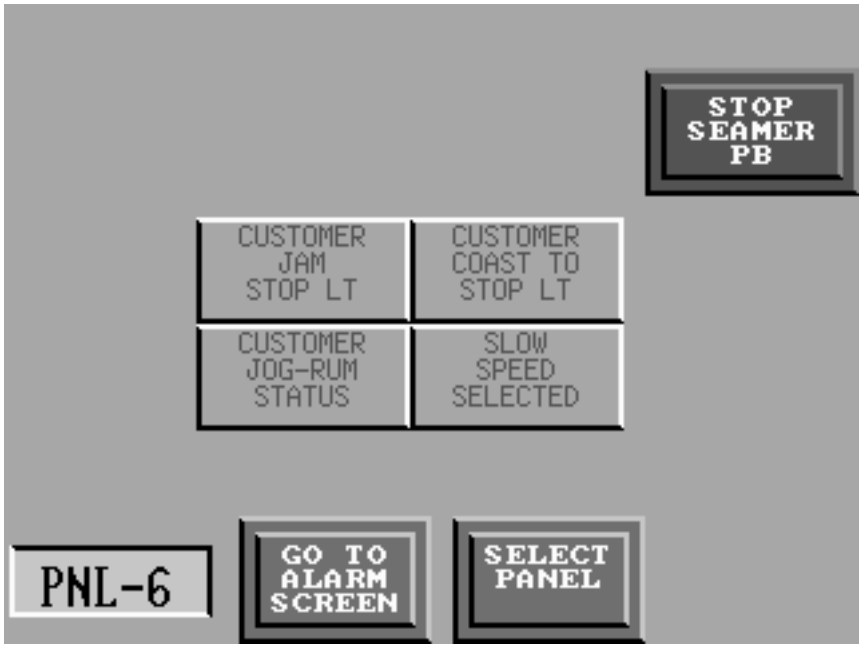

Speed Adjustment Increase Push Button
Actual Seamer Speed Display
Speed Adjust Decrease Push Button
SEAMER SPEED
+###
STOP SEAMER PB
Indicates which speed setpoint is active to be adjusted.
i.e. Slow Speed
SLOW SPEED SETPOINT (150-262)
SEAMER SLOW PB
To adjust Slow speed using the Seamer slow Speed Push Button, then push the increase or decrease Push Button to adjust speed.
FAST SPEED SETPOINT (262-524)
SEAMER FAST PB
Bar Graph Approximate Indicator for Slow Speed
PNL-5
GO TO ALARM SCREEN
SELECT PANEL
CONTROL RESET
The Fast Speed Setpoint adjustment as the slow Speed Adjustment.
Bar Graph Indicator for Fast Speed Setpoint Indicator

Model 62H CTC Operator Instructions

Panel Explanation

Panel - 6

Customer Signal Status Indicator

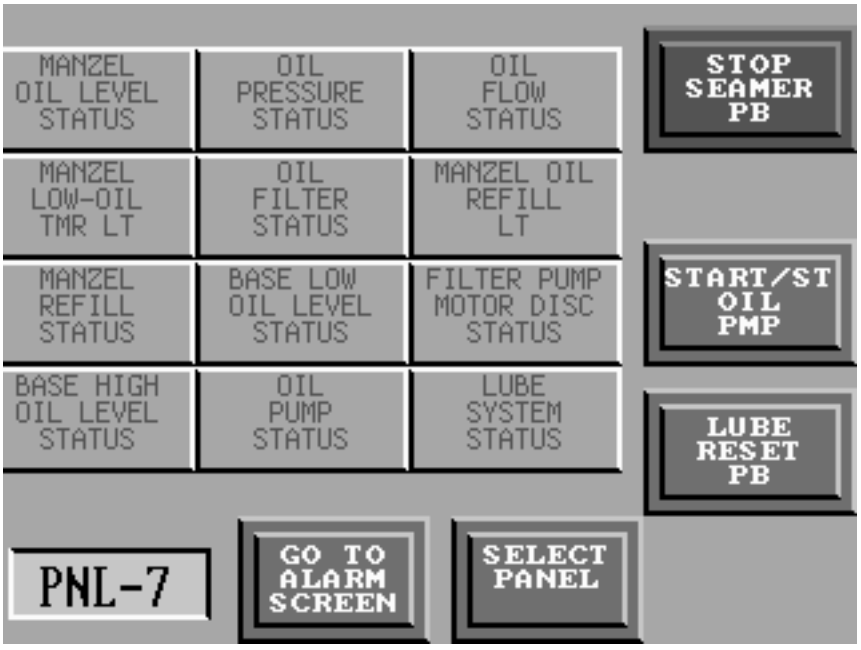


Model 62H CTC Operator Instructions

Panel Explanation

Panel - 7

Oil/Lube System Status Indicator

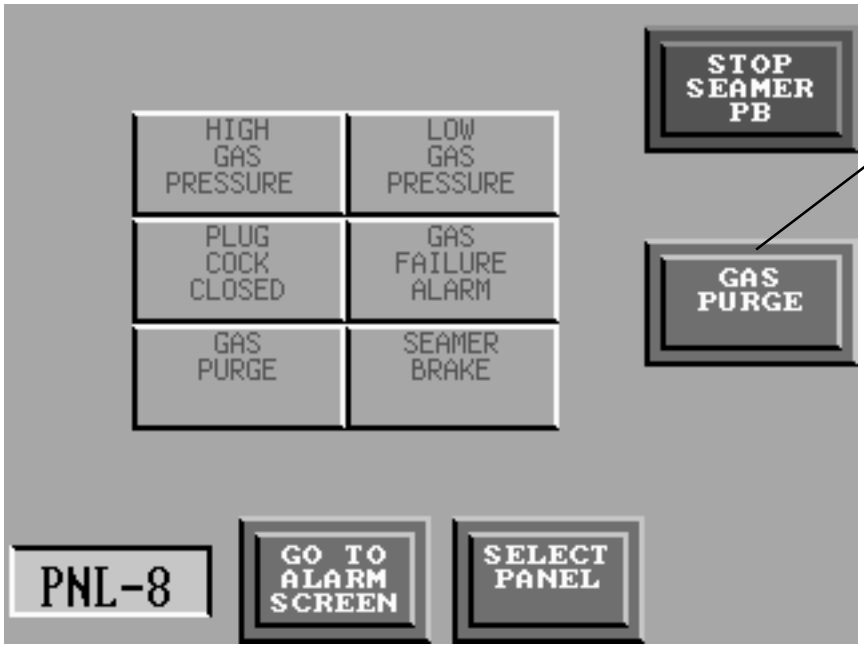


Model 62H CTC Operator Instructions

Panel Explanation

Panel - 8

Gas System Status Indicator



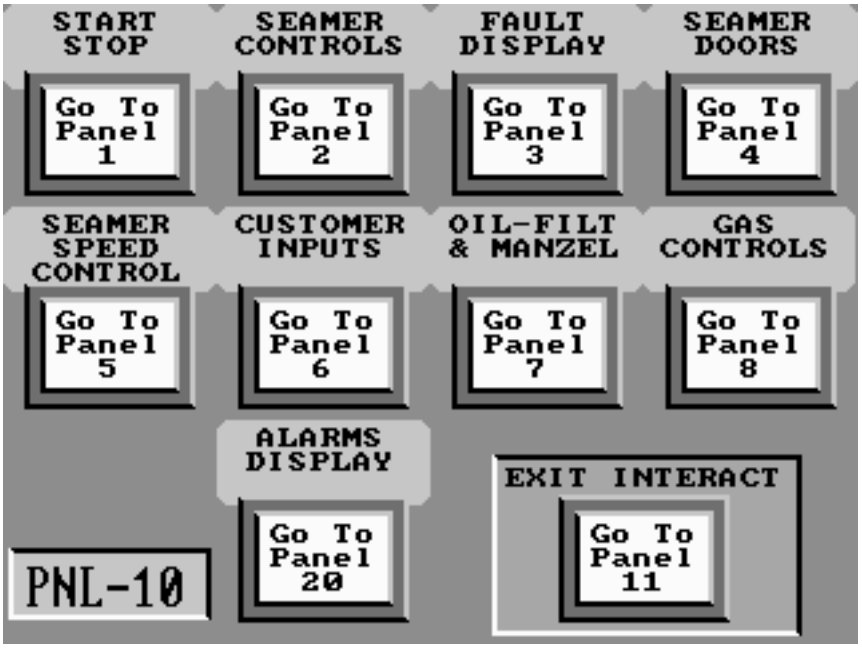
Gas Purge Will Energize the Gas Solenoid for 15 seconds

Model 62H CTC Operator Instructions

Panel Explanation

Panel - 10

Panel Selection Screen

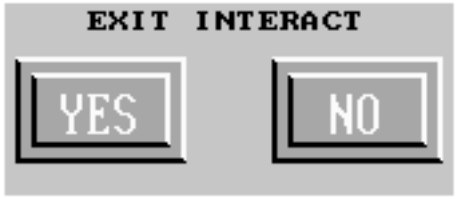


Model 62H CTC Operator Instructions

Panel Explanation

Panel - 11

Exit Interact will Take You to DOS Shell



Model 62H CTC Operator Instructions

Panel Explanation

Alarm Summary Panel

All Alarms that have occurred will be indicated on this page until they are acknowledged and cleared. Active alarms will now be cleared regardless.

To Clear alarm:

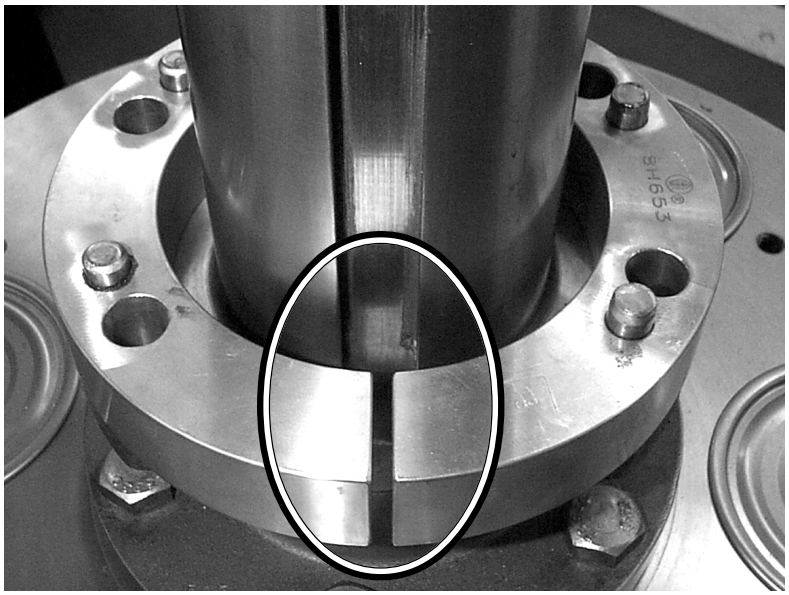
First acknowledge the Alarm by pushing "Ack Alarm".
Then, Push the "Clear Alarm" Button.
Latched alarms will not be cleared until you push the "Control Reset" Push Button

Model 61H and 62H Seamers

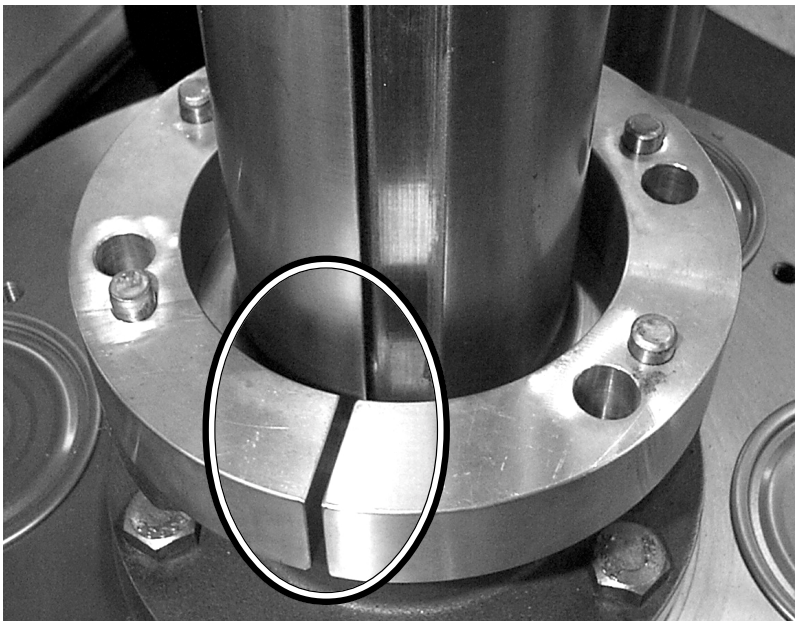
Subject:
Seaming Turret Spacer split
Part #8H653

Description:
Seaming Turret Spacer Split supports the Seaming and Discharge Turret fastened to the Lower Turret Hollow Shaft.

Installation:
Although it is possible to install the Spacer upside down, there is a way to readily determine the correct installation as seen below.



When the Seaming Turret Spacer is installed correctly, the 'saw cut' or split in the Spacer aligns with the Hollow Shaft Keyway.



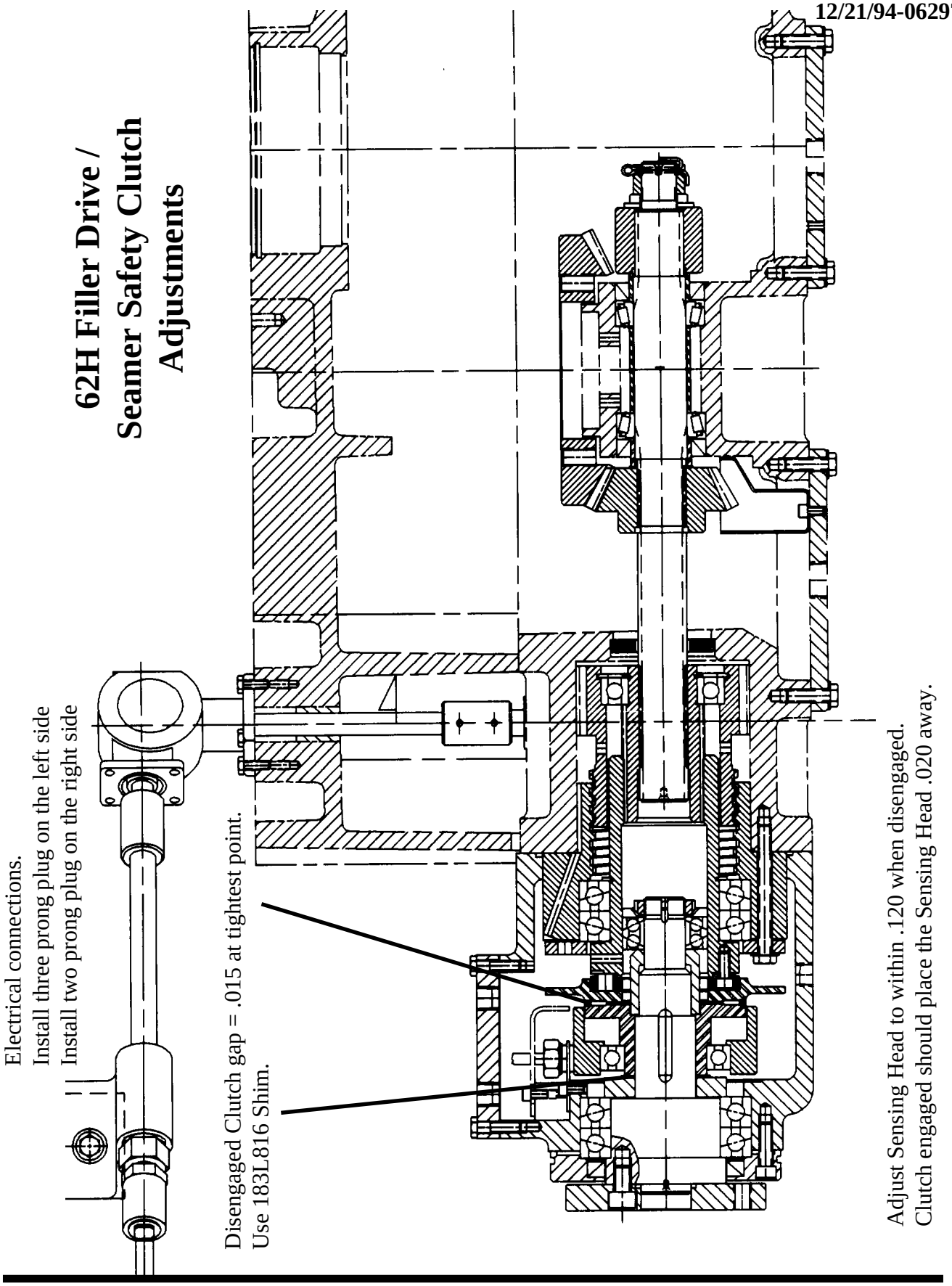
If the Spacer is mounted upside down, the 'saw cut' or split locates to the left of the Shaft Keyway. Clearance holes for fasteners will not align with threaded holes in the Shaft flange.

ANGELUS®

SERVICE NOTICE

12/21/94-06297001

62H Filler Drive / Seamer Safety Clutch Adjustments


Electrical connections.
Install three prong plug on the left side
Install two prong plug on the right side
Disengaged Clutch gap = .015 at tightest point.
Use 183L816 Shim.
Adjust Sensing Head to within .120 when disengaged.
Clutch engaged should place the Sensing Head .020 away.